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Interim Report

I - A2049-12

AN ANALYTICAL AND EXPERIMENTAL
STUDY OF THE STABILITY OF EXTERNALLYPRESSCRIZED, GAS-LUBRICATED
THRUST BEARINGS

bу

L. Licht and H. G. Elrod, Jr.

February 1961

Prepared under

Contract Nonr-2342(00) Task NR 061 - 113

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FOREWORD

This report deals with both the theoretical and experimental phases of an investigation of the stability of externally-pressurized, gas-lubricated bearings.

The analysis, presented in Interim Report No. 1-A2049-4, has been extended and complemented by additional material in Appendices 2 through 7 and is included in this report for the sake of completeness. Detailed descriptions of apparatus, instruments and experiments are given and are supplemented by 65 figures, containing graphs drawings and photographic records.

The theoretical predictions of the present and of earlier analyses are compared with experimental results, areas of further research are suggested and recommendations are made for utilizing the results of the present investigation for design purposes.

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Professor D. D. Fuller, whose counsel greatly contributed to the success of this undertaking, initiated and coordinated the research in gas lubrication at The Franklin Institute. — The Franklin Institute Laboratories, under the direction of Mr. F. L. Jackson, provided ideal conditions and atmosphere in which to carry out this project and the Friction and Lubrication Branch, headed by Mr. W. M. Shugarts, cooperated wholeheastedly in all phases of this investigation. The authors wish to thank Miss S. Goff, Mr. S. Malanoski and Mr. C. Stevenson, who shared in the laborious numerical calculations, and Mr. L. McGinn and Mr. W. Ruegner, who were responsible for the programming of the computer. The meticulously detailed set of engineering drawings of the specificants are crossed in the coarse of the experiments.

The apparatus was manufactured by the Peter J. Salmon Company, Glenside, Pa, and the bearing surfaces were lapped by Dr. if. C. Stein of the Stein Seal Company, Philadelphia. Dr. B. Sternlicht, General Electric Laboratories, Schenectady, New York and Dr. W. Gross, International Business Machines Laboratories, San Jose, California and Dr. S. Ausman, Autonetics, Downey, California, provided useful technical information and offered constructive criticism.

To these people and many others not mentioned specifically, who contributed to the success of this work, the authors owe their gratitude.

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I. ABSTRACT

The subject of this investigation is the stability of externally-pressurized, gas-lubricated bearings. An analysis is made which treate the flow within the gas film on a distributed, rather than on a lumped parameter basis. Rectangular and circular bearing configurations are considered and the effect of several parameters on stability is investigated. Results of the present analysis are compared and contrasted with those obtained from earlier, simplified theories. The experimental program pursues here is guided by the analysis. An apparatus is designed, constructed and instrumented to provide for the variation of governing parameters and for the accurate determination of their critical values. Comparison of theory and experiment is made and the validity of theoretical assumptions, relative to the experimental model, is discussed.

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II. INTRODUCTION

 Instabilities of Good ubricated Rearings and Related Problems - Review of Pertinent Literature

Recent jelveness in space, computer and nuclear technology have precipitated a renewed interest in gas lubrication. Gas bearings are being successfully incorporated in systems precipiting the use of conventional lubricants and rolling elements. To quote contrasting examples of application - gas learnings have been used for small turbine rotors, driven and supported by let exhaust gase a method of gyroscope support in inertial guidance devices, as sensing elements in computers and as low-friction guides in accelerometers, dynamometers, vibration tables and torque reasoning instruments. In nuclear reactors, gas bearings have provided a solution for scaled and isolated systems, in which radioactive gases furnish the only available lubrication medium.

Gas bearings may be broadly classified into two types:

- Self-acting bearings, in which the load capacity is induced through the relative motion of surfaces.
- Externally-pressurized bearings, which rely for their load capacity on an external
 pressure source.

One major difficulty encountered in applications of gas bearings is their susceptibility to self-excited shrations. In unstable, self-acting bearings, the center of the rotating journal may either describe a closed path within the clearance circle, or follow a spiral path until surface contact and destruction take place. This type of instability, generally referred to in literature as "whirl", occurs also with incompressible lubricants, but appears to be particularly troublesome with gases. It has been the subject of numerous theoretical and experimental investigations (36, 37, 38, 39, 40, 41, 42, 43), but its mechanism is not yet fully understood.

The subject of the present inventigation is an instability, associated with externally-pressurized bearings and sometimes referred to as "air" or "pneumatic hammer". It is frequently encountered in valves, regulators and other elements of preumatic and hydraulic control systems [8, 9, 12, 13, 14, 15, 16], and is closely allied to such seemingly unrelated phenomena as self-excited vibrations of fuel injectors [17, 57] and pressure reducers [52], axial auto-oscillations of steam-cushioned turbine rotors [57] and violent pressure fluctuations in fan-ventilated chambers [18, 57]. The "pneumatic hammer" in externally-pressurized bearings is not associated with the steady, relative motion of surfaces, nor greatly influenced by it at moderate rotational speeds. If, however, the amplitude of vibration becomes excessively large in relation to the clearance, surfaces may contact and scoring, or complete destruction ensue. Moreover, even relatively minute auto-oscillations cannot be tolerated in applications involving sensitive instruments, or inertial guidance devices. On the other hand, unless the selection of geometrical and

[†] Numbers in brackets refer to hibliography.

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floid parameters is governed by at least equalitative understanding of the physical mechanism of instability, it is probable that the paring with be unstable in all, or part of the contemplated region of operation.

The phenomenon was observed in externally-pressurized thrust and journal bearings by Muell w [34], Williams [37], Comolet [19], Pigott and Macks [25], Fischer, Chetabim and Fuller [35], Robins in and Sterry [25]. Graneck and Kerr [36], Allen, Stokes and Whitley [32] and many others. Bathe [28] establish demparical criteria for specific bearing configurations used in merical guidance. A number of investigators have speculated on likely causes of instability and have suggested remedial measures, based on observation, or on intuition [26, 30, 32, 33]. The first, rational explanations of the phenomenon in gas lubrication were given independently by Licht, Fulier and Sternlicht [5], who considered the instability of a simple, air-lubricated thrust bearing, and by Richardson [2, 3], who concentrated on the dynamics of externally-pressurized, air-lubricated journal bearings, assuming the initial eccentricity to be small and motion to be limited to a single degree of freedom. More recently, Licht [7] extended the analysis to multiplepad, journal bearings, assuming plane motion of the journal, initially in an eccentric equilibrium position. Roudebush [6] considered the stability of a circular thrust bearing and obtained digital computer solutions for the nonlinear, lumped, fluid-dynamic equations. His conclusions were in agreement with those tased on linearized analyses, although computer solutions were necessarily limited to a number of specific cases.

The analyses referred to in the preceding paragraphs were of the lumped-parameter type and relied or arbitrary, a priori assumptions with regard to variation of pressure profile and flow in the bearing clearance. The objective in making these assumptions was to permit a simple formulation of the problem and to avoid the use of partial differential equations in the mathematical description of the fluid-dynamic phenomena occurring in the bearing clearance.

2. Propose and Outline of the Present Investigation

Because of the large number of parameters which influence the stability of externally-pressurized bearings, and because of the complexity introduced through nonlinearity, the present investigation is restricted to a perturbation analysis. The limitation that perturbation analyses give necessary conditions of instability, not sufficient conditions of stability, is recognized, but linearization has frequently provided a good first approximation in the solution of fundamental problems of fluid dynamics. More specifically, analog and digital computer studies of pneumatic controls indicate that results obtained from linearized equations often compare very favorably with exact solutions [10, 52]. Some encouragement may also be derived from the fact that analog solutions of non-linear equations for a bearing using an incompressible lubricant, but geometrically identical with the model proposed in this investigation, were in good agreement with results obtained from their linearized equilibrates [11].

Results of previous experiments, reported in reference [4], agreed only qualitatively with theoretical predictions of simplified analyses [4, 5]. It was felt that, although the simplified analyses explain a the basic aspects of the physical mechanism of "pneumatic hummer" is gas bearings, the degree of simplification in formulating the problem was excessive. Reclaudson [2, 3] recognized that dynamic changes in pressure-profile depended on time rates of boundary

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anction. In fact, a priori assumptions with regard to pressure-profile variation and mass continuity appear to have little justification, particularly for configurations in which the surface corresponding to the slot constitutes a large fraction of the total bearing area. Equally questionable are the results of simplified analyses, according to which stability is not influenced by the bearing mass [3, 5].

In the thepretical part of the present investigation, while retaining the method of small perturbations and a number of simplifying assumptions, the nonsteady flow in the bearing clearance is treated on a continuous, rather than on a lumped basis. The fluid-dynamic phenomenon in the slot is described by a partial differential equation. The latter is required to natisfy the boundary condition at the outer bearing perimeter and to be compatible with the continuity equation for a centrally located, variable-volume recess, and also with the equation of motion of the bearing muon. Stability analyses are made for axial motion of parallel-surface thrust bearings. Rectangular and circular configurations *** are considered and stability boundaries are obtained to show the effect of several, important locating parameters and to show how the results compare with those obtained from lumped-parameter theories.

In the experimental part of the present investigation, the bearing is circular and identical in geometry to the theoretical model. The surface bounded by the perimeter of a centrally-located, adjustable-volume recess, constitutes a small fraction of the total bearing area, in order to hinder the escene of fluid and magnify the trapping and squeezing effect in the slot. Provision is also made to vary the bearing mass without altering the load, in order to observe the influence of mass on stability.

[†] See also Appendix 2.

¹¹ Schematics, drawings and photographs of actual thrust plates are shown in Figures 1, 7, 8, 13, 19 and 20.

III. ANALYSIS[†]

1. Derivation of Characteristic Equations

In what follows, causations are simultaneously developed for the rectangular and circular configurations shown in Figures 1a and 1b. Figurations applicable to both geometries are denoted with the numbers. Those denoted by the letter "a" refer to the rectangular geometry, while these denoted by the letter "b" refer to the circular geometry.

Launtions (1) through (1) are those developed by G. I. Taylor and P. G. Saffman [1], who investigated compressibility effects at low Reynolds number. One case they considered consisted of two parallel discs, separated by a parrow air gap, when rotation was accompanied by small amplitude, forced vibration in the axial direction. By contrast, the present investigation concerns itself with the onset of self-excited oscillations. It differs also because, in the absence of rotation, third flow is induced by means of an external pressure source connected to an internal, variable-volume reservoir.

It is assumed that forces due to inertia are small compared with those due to viscous stresses, and that the pressure gradient is the transverse direction of the slot is negligible. The amplitude of oscillations in the anticipated frequency band width can be considered arbitrarily small in congarison with the magnitude of the gap width. The mean flow velocity in the annulus can then be obtained from the reduced Navier-Stokes equation and witten as:

$$\overline{u} = -\frac{H^2}{12\mu} \frac{\partial P}{\partial x} \tag{1a}$$

$$\overline{u} = -\frac{H^2}{12\mu} \frac{\partial P}{\partial r} \tag{1b}$$

Since the dimension of the annulus separating the metallic surfaces is small in comparison with the linear dimension of the slot, it is reasonable to assume that conductivity prevents any appreciable variation in temperature and that the relation

$$\frac{\mathbf{P}}{\rho} = \text{constant}$$
 (2)

represents the thermodynamic process to a sufficient degree of approximation.

[†] Material contained in this section was presented at the 23rd National Conference of the Applied Mechanics Division, ASME, June 1960, and was published under the title "A Study of the Stability of Externally Pressurized Cast Division, J. Licht and H. Lind, Jr., Journal of Applied Mechanics, Vol. 27, No. 2, June 1960, pp. 250-258.

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The continuity equation then becomes:

$$\frac{\partial}{\partial t} (\rho H) + \frac{\partial}{\partial x} (\rho H \overline{u}) = 0$$
 (3a)

$$\frac{\partial}{\partial t} (\rho H) + \frac{1}{i} \frac{\partial}{\partial r} (r \rho H \overline{u}) = 0$$
 (35)

Substitution of equations (1) and (2) in the continuity equation (3) yields a dynamic lubricition equation:

$$\begin{cases} \frac{\partial}{\partial x} P\left(\frac{\partial P}{\partial x}\right) = \frac{12\mu}{H^3} \frac{\partial}{\partial t} (PH) \\ \frac{1}{r} \frac{\partial}{\partial r} \left(rP \frac{\partial P}{\partial r}\right) = \frac{12\mu}{H^3} \frac{\partial}{\partial t} (PH) \end{cases}$$
(4a)

$$\frac{1}{r} \frac{\partial}{\partial r} \left(r P \frac{\partial P}{\partial r} \right) = \frac{12\mu}{H^3} \frac{\partial}{\partial t} \left(PH \right) \tag{4b}$$

The basic assumptions and the derivation of these equations are given in Appendix 6.

Equation (4) must satisfy the boundary condition

$$P(R, t) = P_{at}$$
 (5b)

$$P(X,t) = P_{at} (5b)$$

and be compatible with the equation of motion!:

$$\begin{cases} m \frac{d^{2}H}{dt^{2}} = 2X_{r}(P_{r} - P_{ro}) + 2\int_{X_{r}}^{X} (P_{r} - P_{o}) dx + F(t) \\ m \frac{d^{2}H}{dt^{2}} = \pi R_{r}^{2} (P_{r} - P_{ro}) + 2\pi \int_{R_{r}}^{R} (P_{r} - P_{o}) r dr + F(t) \end{cases}$$
 (6b)

$$m \frac{d^{2}II}{dt^{2}} = \pi R_{r}^{2} (P_{r} - P_{ro}) + 2\pi \int_{R_{r}}^{R} (P - P_{o}) r dr + F(t)$$
 (6b)

in which F(t) is the excitation function.

TTLe effect of external damping in negligibly small

In addition, the continuity equation of the variable-volume recess is as follows:

$$\frac{dM_r}{dt} = \pi_1 - \pi_2 \tag{7}$$

In expressing the quantities on the right hand side of equation (7), it is assumed that the flow can be treated as quasi-steady. Theoretical and experimental investigations of pulsating flow through orifices were conducted by Schultz-Grunow [46], who discussed the conditions under which instantaneous flow cates could be evaluated from steady-flow equations and gave criteria for their applicability. To express the left hand side of equation (7), it is necessary to describe an extremely complex process, associated with simultaneous charging and discharging of a variable-volume container. In the present analysis it will be assumed that fluid properties throughout the recess volume are uniform at any instant of time and that the process may be adequately described by the pressure-density relation P py = constant. The quasi-static charging and discharging of an adiabatic container, for example, may be considered as isontropic to the first degree of approximation, peef. i mixing of entering gas being assumed. Experiments conducted by Shearer [9] and Skinner and Wagner [56] also indicate that, for relatively rapid rates of charging and discharging, the assumption $P(\rho)^{\gamma}$ constant is reasonable. The effect of wave propagation, heat transfer and preventibilities, associated with the processes of charging and discharging of fixed and variable volume containers, cannot always be neglected [51, 53, 54, 55]. However, assumptions identical with those made in implementing equation (7) have been frequently and successfully employed in related problems, in the field of pneumatic controls and regulators [9.14.52]. Consequently, the quantities appearing in equation (7) are expressed as follows:

$$W_1 = 2\left(\frac{\pi d_N^2}{4}\right) \left[\frac{y}{RT_0} \left(\frac{2}{y+1}\right)^{\frac{y+1}{y+1}} (P_s P_r - P_r^2)\right]^{T_t}$$
(8)

$$\begin{cases} W_2 = -\frac{\Pi^3}{6\mu} \left(\rho \frac{\partial P}{\partial x} \right)_{X_T} \\ W_2 = -\frac{\pi H^3}{6\mu} \left(r \rho \frac{\partial P}{\partial x} \right)_{R_T} \end{cases}$$
(9a)

$$W_2 = -\frac{\pi H^3}{6\mu} \left(r \rho \frac{\partial P}{\partial r} \right)_{R_2}$$
 (9b)

The flow through the supply nozzle can be approximated closely by a quadrant of an ellipse whenever P_{r}/P_{u} is considerably above the critical-pressure ratio. This is Fliegner's approximation, and is convenient for computational purposes.

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$$\begin{cases} M_r = 2X_r(\delta + H)\rho_r \\ M_r = \pi R_r^2(\delta + H)\rho_r \end{cases}$$
 (10a)

while the pressure-density relation for the recess volume is taken as:

$$\left(\frac{\rho_r}{\rho_{ro}}\right)^{\gamma} = \frac{P_r}{P_{ro}} \tag{11}$$

In the next step the perturbation quantities

$$P_r - P_o = p$$

$$P_r - P_{ro} = p_r$$

$$H - H_o = h$$
(12)

and their derivatives are introduced. Neglecting their squares and cross products as quantities of higher order, we obtain instead of equations (4), (6) and (7) a set of corresponding expressions.

The nonlinear, partial differential equation (4) is replaced by one which is linear, but contains variable coefficients.

Thus in terms of perturbation quantities we have:

$$\begin{cases}
\frac{\partial^{2} P}{\partial x^{2}} + \left(\frac{2P_{o}'}{P_{o}}\right) \frac{\partial P}{\partial x} + \left(\frac{P_{o}''}{P_{o}}\right) P = \frac{12\mu}{H_{o}^{2}} \left(\frac{1}{P_{o}} \frac{\partial P}{\partial r} + \frac{1}{H_{o}} \frac{dh}{dt}\right) \\
\frac{\partial^{2} P}{\partial r^{2}} + \left(\frac{2P_{o}'}{P_{o}} + \frac{1}{r}\right) \frac{\partial P}{\partial r} + \left(\frac{P_{o}''}{P_{o}} + \frac{1}{r} \frac{P_{o}'}{P_{o}}\right) P = \frac{12\mu}{H_{o}^{2}} \left(\frac{1}{P_{o}} \frac{\partial P}{\partial r} + \frac{1}{H_{o}} \frac{dh}{dt}\right) \end{cases} (13a)$$

$$\frac{\partial^2 p}{\partial r^2} + \left(\frac{2P_o'}{P_o} - \frac{1}{r}\right)\frac{\partial p}{\partial r} + \left(\frac{P_o''}{P_o} + \frac{1}{r}\frac{P_o'}{P_o}\right)p = \frac{12\mu}{H_o^2}2\left(\frac{1}{P_o}\frac{\partial p}{\partial t} - \frac{1}{H_o}\frac{dh}{dt}\right)$$
(13b)

From equation (6) we obtain.

$$\int m \frac{d^{2}h}{ct^{2}} = 2X_{r}p_{r} + 2\int_{X_{r}}^{X} p \, dx + f(t)$$

$$= \int m \frac{d^{2}h}{dt^{2}} = \pi R_{r}^{2} p_{r} + 2\pi \int_{R_{r}}^{R} pr \, dr + f(t)$$
(14a)

in which fet) is the disturbance,

r quation (7) reduces to

$$\begin{cases} K_1 \frac{dh}{dt} - K_4 h = (K_3 + K_5) \rho_r + K_6 \frac{\partial \rho_r}{\partial \tau} - K_2 \frac{\partial \rho_r}{\partial t} \\ C_1 \frac{dh}{dt} - C_4 h = (C_3 + C_5) \rho_r + C_6 \frac{\partial \rho_r}{\partial \tau} - C_2 \frac{\partial \rho_r}{\partial t} \end{cases}$$
(15a)

in which the coefficients K_1 and C_4 represent the quantities listed in the following:

$$K_{1} = \left(\frac{\partial W_{r}}{\partial H}\right) - \frac{2V_{r}P_{ro}}{ST_{o}}$$

$$K_{2} = \left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{W_{o}}{P_{ro}}$$

$$K_{3} = \left(\frac{\partial W_{1}}{\partial P_{r}}\right)_{o} = \frac{2V_{r}H_{o}}{2P_{ro}} \left(\frac{\partial}{H_{o}} + 1\right)$$

$$K_{4} = \left(\frac{\partial W_{2}}{\partial H}\right)_{o} = -\frac{3W_{o}}{H_{o}}$$

$$K_{5} = -\left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{W_{o}}{P_{ro}}$$

$$K_{6} = -\left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{2P_{ro}W_{o}}{A_{o}}$$

$$K_{7} = \left(\frac{\partial W_{1}}{\partial P_{ro}}\right)_{o} = \frac{W_{o}}{2P_{ro}} \left(\frac{P_{s}}{P_{ro}} - 2\right)$$

$$K_{8} = -\left(\frac{\partial W_{2}}{\partial R}\right)_{o} = -\frac{2P_{ro}W_{o}}{A_{o}}$$

$$K_{9} = -\left(\frac{\partial W_{2}}{\partial R}\right)_{o} = -\frac{2P_{ro}W_{o}}{A_{o}}$$

$$K_{1} = -\left(\frac{\partial W_{2}}{\partial H}\right)_{o} = -\frac{3W_{o}}{H_{o}}$$

$$K_{2} = -\frac{2P_{ro}W_{o}}{A_{o}}$$

$$K_{3} = -\frac{P_{ro}^{2} - P_{st}^{2}}{A_{o}}$$

$$K_{4} = -\left(\frac{\partial W_{2}}{\partial H}\right)_{o} = -\frac{3W_{o}}{H_{o}}$$

$$K_{5} = -\left(\frac{\partial W_{2}}{\partial R}\right)_{o} = -\frac{W_{o}}{A_{o}}$$

$$K_{7} = -\frac{P_{ro}^{2} - P_{st}^{2}}{A_{o}}$$

$$K_{8} = -\frac{P_{ro}^{2} - P_{st}^{2}}{A_{o}}$$

$$K_{9} = -\frac{P_{ro}^{2} - P_{st}^{2}}{A_{o}}$$

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$$C_{1} = \left(\frac{\partial M_{r}}{\partial H}\right)_{o} = \frac{\pi R_{r}^{2} P_{r,o}}{RT_{o}}$$

$$C_{2} = \left(\frac{\partial M_{r}}{\partial P_{r}}\right)_{o} = \frac{\pi R_{r}^{2} H_{o}}{yRT_{o}} \left(\frac{\delta}{H_{o}} + 1\right)$$

$$C_{3} = \left(\frac{\partial M_{1}}{\partial P_{r}}\right)_{o} = \frac{W_{o}}{2P_{r,o}} \left(\frac{\delta}{H_{o}} + 1\right)$$

$$C_{4} = -\left(\frac{\partial M_{2}}{\partial H}\right)_{o} = \frac{W_{o}}{r-R_{r}} \left(\frac{\partial M_{o}}{H_{o}} + 1\right)$$

$$C_{5} = -\left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{W_{o}}{P_{r,o}} \left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{2R_{r}P_{r,o}W_{o}}{B_{o}}$$

$$C_{6} = -\left(\frac{\partial W_{2}}{\partial P}\right)_{o} = -\frac{2R_{r}P_{r,o}W_{o}}{B_{o}}$$

$$C_{7} = \left(\frac{\partial W_{1}}{\partial P}\right)_{o} = \frac{W_{o}}{2P_{r,o}} \left(\frac{P_{s}}{P_{r,o}} - 2\right)$$

$$P_{o}(r) = \left(\frac{P_{r,o}^{2} + B_{o}\log_{e}\frac{P_{r,o}}{R_{r}}}{R_{r}}\right)^{\frac{N}{2}}$$

$$B_{o} = -\frac{P_{r,o}^{2} - P_{at}^{2}}{\log_{e}\frac{R}{R_{r}}}$$

$$(16b)$$

Solutions of equation (13) must satisfy equations (14) and (15) as well as the boundary condition

$$\begin{cases} p(X, t) = 0 & (17a) \\ p(R, t) = 0 & (17b) \end{cases}$$

The first space derivative in equation (13) can be eliminated by means of the following substitution:

$$\begin{cases} p = \frac{v}{P_0} = \frac{v}{z^{\frac{1}{2}}} \\ p = \frac{v}{r^{\frac{1}{2}}P_0} \end{cases}$$
 (13a)

Introducing the new variable v into equations (13), (14) and (15) we take the Laplace transform under the assumption of initial rest conditions.

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then with

$$\hat{x}_{t}(x) = \overline{V} = \int_{0}^{\infty} e^{-st} dt$$

$$\hat{x}_{t}(h) = \overline{h} = \int_{0}^{\infty} h e^{-st} dt$$

$$\hat{x}_{t}(f) = \overline{f} = \int_{0}^{\infty} f e^{-st} dt$$

equation (i3) transforms to:

$$\overline{V}'' - \frac{\epsilon s}{z^{\frac{1}{3}}} \overline{V} = \epsilon s z^{\frac{1}{2}} \frac{\overline{h}}{\overline{H}_{o}}$$

$$\overline{V}'' + \left(\frac{1}{4r^{2}} - \frac{\eta s}{P_{o}}\right) \overline{V} = \eta s r^{\frac{1}{2}} P_{o} \frac{\overline{h}}{\overline{H}_{o}}$$
(19a)

in which

$$\begin{cases} r = \frac{12\mu}{H_o^2 A_o^2} = \frac{12\mu}{H_o^2} \left(\frac{Y - X_r}{\Gamma_{ro}^2 - \Gamma_{at}^2} \right)^2 \\ \eta = \frac{12\mu}{H_o^2} \end{cases}$$
 (20a)

Equation (14) transforms to:

$$\begin{cases} ms^{2} \frac{\bar{h}}{H_{o}} - \frac{2N_{r}}{H_{o}P_{ro}} (\bar{V})_{P_{ro}^{2}} + \frac{2(X - X_{r})}{H_{o}(P_{ro}^{2} - P_{at}^{2})} \int_{P_{ro}^{2}}^{P_{at}^{2}} \frac{\bar{V}}{z^{\frac{1}{2}}} dz = \bar{f}(s) \end{cases}$$

$$(21a)$$

$$ms^{2} \frac{\bar{h}}{H_{o}} \frac{\pi R_{r}^{3/2} (\bar{V})_{R}}{H_{o}^{2}P_{ro}^{2}} - \frac{2\pi}{H_{o}} \int_{R_{r}}^{R} \frac{\bar{V}_{r}^{\frac{1}{2}}}{i^{\frac{1}{2}}} dr = \bar{f}(s)$$

$$(21b)$$

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Figuation (15) transforms to:

$$\begin{cases} (sK_1 - K_4) \frac{\tilde{h}}{H_0} + (sK_2 - K_3) \frac{(\overline{V})_{P_{r0}^2}}{H_0 P_{r0}} - \frac{2P_{r0}}{H_0} K_5 \left(\frac{\partial \overline{V}}{\partial z}\right)_{P_{r0}^2} = 0 \\ (sC_2 - C_4) \frac{\tilde{h}}{H_0} + \left(sC_2 - C_3 + C_5 \frac{P_{r0}^2}{B_0}\right) \frac{(\overline{V})_{R_r}}{H_0 R_r^{-1} P_{r0}} - \frac{2R_r^{\frac{14}{5}} P_{r0}}{B_0 H_0} C_5 \left(\frac{\partial \overline{V}}{\partial r}\right)_{R_r} = 0 \end{cases}$$
(22a)

which the complete to and the have been replaced by means of the identity

$$\begin{cases} K_6 = \frac{2P_{ro}^2}{A_o} K_5 & (23a) \\ C_6 = \frac{2R_r P_{ro}^2}{B_o} C_5 & (23b) \end{cases}$$

Finally, the boundary condition (17) transforms to

$$\begin{cases} \overline{V}(P_{at}^2, s) = 0 \\ \overline{V}(R, s) = 0 \end{cases}$$
 (24a)

Furthermore, by integrating equation (19) between the appropriate limits, we can replace the integral in equation (21). For this purpose we have:

$$\begin{cases}
\int_{|\mathbf{P}_{r0}|^{2}}^{|\mathbf{P}_{r0}|^{2}} \frac{\overline{V}}{z^{l_{0}}} dz = \frac{2}{3} \left(\mathbf{P}_{r0}^{3} - \mathbf{P}_{at}^{3} \right) \frac{\overline{\mathbf{h}}}{\mathbf{H}_{0}} = \frac{1}{\epsilon s} \left[\left(\frac{\partial \overline{V}}{\partial z} \right)_{\mathbf{P}_{r0}^{2}} - \left(\frac{\partial \overline{V}}{\partial z} \right)_{\mathbf{P}_{at}^{2}} \right] \\
\int_{|\mathbf{R}_{r}|^{2}}^{|\mathbf{R}|} \frac{\overline{V} r^{l_{1}}}{|\mathbf{P}_{0}|} dr = -3 \frac{\overline{\mathbf{h}}}{|\mathbf{H}_{0}|} + \frac{1}{2} \left[\mathbf{R}_{r}^{l_{1}} \left(\frac{\partial \overline{V}}{\partial r} \right)_{\mathbf{R}_{r}} - \mathbf{R}^{l_{2}} \left(\frac{\partial \overline{V}}{\partial r} \right)_{\mathbf{R}} - \frac{(\overline{V})_{\mathbf{R}_{r}}}{2 \mathbf{R}_{r}} \right]
\end{cases} (25b)$$

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in which

$$= \int_{0}^{R} P_{\sigma}(\mathbf{r}) e \, d\mathbf{r} \tag{26b}$$

The for 20 mg integral is expressed explicitly in Appendix 1.

A particular solution of equation (19) is:

$$\begin{cases}
\bar{V}_{p} = -\frac{\bar{h}}{H_{o}} z
\end{cases} (27a)$$

$$\begin{cases}
\bar{V}_{n} = -\frac{\bar{h}}{H_{o}} r^{4a} V_{o}^{2}(r)
\end{cases} (27b)$$

If \mathbf{v}_1 and \mathbf{v}_{11} are independent solutions which satisfy the homogeneous part of the differential equation (19), then

$$\left(y(z, c) - \frac{v_1(z)v_{11}(\zeta) - y_1(\zeta)v_{11}(z)}{v_1(P_{10}^2)v_{11}(P_{at}^2) - v_1(P_{at}^2)y_{11}(P_{ro}^2)}\right)$$
(28a)

$$Q(\mathbf{r}, p) = \frac{y_{\rm I}(\mathbf{r})y_{\rm H}(\rho) - y_{\rm I}(\rho)y_{\rm H}(\mathbf{r})}{y_{\rm I}(\mathbf{R}_{\rm f})y_{\rm H}(\mathbf{R}) - y_{\rm I}(\mathbf{R})y_{\rm H}(\mathbf{R}_{\rm f})}$$
(28b)

are also solutions having the following properties:

$$()(z, z) = 0$$

$$()(P_{10}^{2}, P_{at}^{2}) = -()(P_{at}^{2}, P_{ro}^{2}) = 1$$

$$\frac{\partial \zeta}{\partial \zeta}(z, z) = \text{constant}^{\dagger}$$
(29a)

The Wronskian of second-order differential equations having the form y" + f(x)y = 0 is a constant.

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$$O(P_{\mathbf{r}}, \mathbf{R}) = O(\mathbf{h}, \mathbf{R}_{\mathbf{r}}) - 1$$

$$\frac{\partial O}{\partial t} (\mathbf{r}, \mathbf{r}) = \text{constant}^{d}$$
(29b)

The solution of (19) which satisfies the boundary condition (24) can then be written as:

$$\begin{cases}
\overline{V} : \overline{\Lambda} Q(P_{at}^{2}, z) : \frac{\overline{h}}{H_{o}} \left[P_{at}^{2} Q(P_{ro}^{2}, z) - z \right] \\
\overline{V} : \overline{\Lambda} Q(R, r) : \frac{\overline{h}}{H_{o}} \left[R^{t_{2}} P_{at}^{2} Q(R_{r}, r) - r^{t_{2}} P_{o}^{2} (r) \right]
\end{cases} (30a)$$

in thich $\overline{\chi}(s)$ and $\overline{h}(s)$ are determined from equations (21) and (22).

Using equation (25) and substituting into equation (22) the boundary values of \overline{V} and its derivatives obtained by differentiation of equation (30), we have at our disposal two simultaneous equations for the determination of $\overline{\Lambda}(s)$ and $\overline{h}(s)$. The "two by two" determinant formed from the coefficients of the homogeneous parts of these equations is then set equal to zero. The location in the complex plane of roots of this characteristic equation determines the stability of the bearing. The characteristic determinant referred to in the foregoing is as follows:

 $^{^{\}dagger}$ The Wronskian of second-order differential equations having the form y'' + f(x)v = 0 is a constant.

$= P_{r,s} \left(\frac{P_{r,s}^{-1} - P_{r,s}^{-2}}{\sqrt{r}} \right) e^{-\frac{1}{r}} \left(P_{s,s}^{-2} - P_{r,s}^{-2} \right) + P_{s,s}^{-2} + P_{s,s}$	$\frac{K_3}{2K_5} = \frac{K_3}{2K_5} + \left[P_{r0}^2 \frac{40}{315} (P_{v1}^2, P_{r0}^2) \right]$
$\frac{\ln H_0}{2V_t} \left(\frac{P_{to}^2 + P_{at}^2}{V_t} \right) s^3 + \frac{2}{3} \left(P_{to}^3 + P_{at}^5 \right) \epsilon s$ $= \frac{2V_t}{V_t} \left(\frac{V}{V_t} - 1 \right) s^3 + \frac{2}{3} \left(P_{to}^3 + P_{at}^5 \right) \epsilon s$ $= \left[P_{to}^2 \frac{\partial \psi}{\partial \xi} \left(P_{at}^2 + P_{to}^2 \right) + P_{at}^2 \frac{\partial \psi}{\partial \xi} \left(P_{to}^2 + P_{at}^2 \right) \right]$ $= \left(P_{to}^2 + P_{tt}^2 \right) \frac{\partial \psi}{\partial \xi} \left(z, z \right)$	$\frac{K}{2N_5} \frac{P_{to}}{P_{ro}} = -\frac{V_4}{2V_5} \frac{P_{to}}{P_{ro}} + \left[P_{ro}^2 \frac{\partial Q}{\partial z_r^2} (P_{nt}^2, P_{ro}^2) - P_{nt}^2 \frac{\partial Q}{\partial z_r^2} (z, z) + 1 \right]$

$$\frac{P_{r_0}R_r^{-2}\eta}{2P_{n_1}^{-2}} = + \left\{ \left(\frac{P_{r_0}}{P_{n_1}} \right)^2 R_r \frac{\partial Q}{\partial \rho} \left(v_r, R_r \right) - \left(\frac{P_{r_0}}{P_{n_1}} \right)^2 R_r^{-2} R^{-2} R^{-2} R^{-2} R^{-2} \left(\frac{\partial Q}{\partial \rho} \left(v_r, r_r \right) + \frac{1}{2} \left(\frac{P_{r_0}}{P_{n_1}} \right)^2 \right\}$$

$$\frac{C_2}{2C_5} \frac{\left(\frac{P_{10}}{P_{a1}}\right)^2 - 1}{\log_e \frac{R}{R_r}} s - \frac{C_3}{2C_5} \frac{\left(\frac{P_{10}}{P_{a1}}\right)^2 - 1}{\log_e \frac{R}{R_r}}$$

$$- \left\{ \left(\frac{P_{10}}{P_{a1}}\right)^2 R_r \frac{\partial Q}{\partial \rho} (R_r R_r) + \frac{1}{2} \left(\frac{P_{10}}{P_{a1}}\right)^2 \right\}$$

$$\frac{nH_0 \eta}{2\pi P_{at}^2} s^3 + \frac{\eta \, \delta s}{P_{at}^2} - \left\{ R \, \frac{\partial Q}{\partial \rho} \left(R_r , R \right) \right.$$

$$+ \left(\frac{P_{ro}}{P_{at}} \right)^2 R_r \, \frac{\partial Q}{\partial \rho} \left(R, R_r \right) - \left[\left(\frac{P_{ro}}{P_{at}} \right)^2 + 1 \right] \times$$

$$\times \left. R_r^{ \frac{1}{2} R_r^{ \frac{1}{2} \beta}} \frac{\partial Q}{\partial \rho} \left(r, r \right) + \frac{1}{2} \left[\left(\frac{P_{ro}}{P_{at}} \right)^2 - 1 \right] \right\}$$

$$\frac{C_1}{2C_5} \left(\frac{H_0}{P_{ro}} \right)^{\left(\frac{P_{ro}}{P_{nt}} \right)^2 - 1} \\ + \left(\frac{P_{ro}}{P_{nt}} \right)^2 \frac{1}{\log_F \frac{R}{R_T}} \right. \\ + \left(\frac{P_{ro}}{P_{nt}} \right)^2 \frac{1}{R_T} \frac{\frac{3Q}{9} \left(R, R_T \right) - R_T^{-\frac{1}{N}} R^{\frac{N}{N}} \frac{\frac{3Q}{9}}{\frac{3Q}{9}} \left(r, r \right)}{\frac{1}{2} \left(\frac{P_{ro}}{P_{nt}} \right)^2 - \frac{\left(\frac{P_{ro}}{P_{nt}} \right)^2 - 1}{\frac{1}{2} \left(\frac{P_{ro}}{P_{nt}} \right)^2 - \frac{1}{2} \left(\frac{P_{ro}}{P_{nt}} \right)^2 -$$

2. Stability Boundary - Evaluation of Critical (Limiting) Parameters

Further progress in the analysis depends on a knowledge of the solutions y_1 and y_{11} of the homogeneous part of equation (19). I ven with such knowledge the location of roots in the complex plane of the characteristic equation (31) might be very involved. Our interest lies in assessing the limiting values of certain hearing parameters which influence stability. Within limits of applicability of our equations, we are guided in the expected range of their magnitudes by results obtained by means of a simplified analysis summarized in Appendix 2. Different approaches were employed for the rectangular and circular geometries and these are described in what follows:

a. Rectangular Geometry

The homogeneous part of equation (19a) is

$$y'' - \epsilon s z^{-\frac{1}{2}} y = 0 ag{32a}$$

Two independent solutions, which involve Bessel functions of order ± 2/3, can be written as [60]:

$$y_{1} = z^{\frac{1}{2}} J_{\pm \frac{2}{3}} \left(\frac{4}{3} z^{\frac{3}{4}} i \sqrt{\epsilon s} \right)$$
 (33a)

in which + 2 3 corresponds to I and - 2/3 to II.

The series representing the Bessel function $J_{\nu}(2i\lambda^{1/2})$ can be written as [61]:

$$J_{\nu}(2i\lambda^{\frac{1}{2}}) = (i\lambda^{\frac{1}{2}})_{\nu} \left[\frac{1}{\Gamma(\nu+1)} + \frac{\lambda}{1!\Gamma(\nu+2)} + \frac{\lambda^{2}}{2!\Gamma(\nu+3)} + \cdots \right]$$
 (34a)

Wieh

$$\nu = \pm \frac{2}{3}$$
 and $2i\lambda^{\frac{1}{2}} = \frac{4}{3}z^{\frac{3}{4}}i\epsilon s$

the first four terms of the expansion of y_I and y_{II} become

$$y_{I} = \frac{\left(\frac{2}{3} i \sqrt{\epsilon s}\right)^{2/3}}{\Gamma\left(\frac{2}{3}\right)} \left[\frac{3}{2} z + \frac{2}{5} z^{5/2} (\epsilon s) + \frac{1}{30} z^{8/2} (\epsilon s)^{2} + \frac{2}{1485} z^{11/2} (\epsilon s)^{3}\right]$$
(35a)

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$$v_{11} = -\frac{\left(\frac{2}{3} i \sqrt{\epsilon}\right)^{-2} 3}{1 \left(\frac{1}{3}\right)} \left[1 + \frac{4}{3} z^{3/2} (\epsilon s) + \frac{2}{9} z^{6/2} (\epsilon s)^{2} + \frac{8}{567} z^{9/2} (\epsilon s)^{3}\right]$$
(36a)

These truncated series are then substituted into the expression $Q(z,\zeta)$ in (25a) and the derivative $(\partial Q/\partial \zeta)(z,\zeta)$ evaluated with z and ζ assuming the boundary values of P_{at}^2 and P_{at}^2 in the order indicated in the components of the characteristic determinant (31a). In forming the expressions for the afore-mentioned derivatives of Q, we retain in all subsequent multiplications, divisions, and so on, terms of order s^3 and lower. The assumption that higher powers in s may be neglected, because of the relative smallness of their coefficients, is justified post factually noting the magnitude of the complex-conjugate roots $s=\pm i\,\omega$ of the characteristic cubic to which the determinant (31a) is thus reduced. The coefficients of this cubic and those obtained by means of the simplified analysis in Appendix 2 are not the same. The effect of this difference in results is best illustrated by reference to Figure 3 and the table of results in Appendix 3.

b. Circular Geometry.

In this case computer solutions for a set of discrete values of $s = i\omega$ on the axis of the imaginaries were obtained. The probable range of values for ω was dictated by predictions based on the simplified analysis and by taking into account the difference in the results of the two analyses for the rectangular case. Stability was assessed from physical conditions rather than proved. If we write

$$\xi = \frac{r}{R_r} : \sigma = \frac{12\mu\omega R_r^2}{P_{ro}H_o^2} : s = i\omega; \beta - \frac{1 - \left(\frac{P_{at}}{P_{ro}}\right)^2}{\log_e \frac{R}{R_r}}$$

then the homogeneous part of equation (19b) becomes

$$y'' + \left[\frac{1}{4\xi^2} - \frac{i\alpha}{(1 - \beta \log_e \xi)^{\frac{1}{2}}} \right] y = 0$$
 (37b)

he solutions of which

$$y_{I} = \phi_{I}(\xi) + i\phi_{I}(\xi)$$

$$II \qquad II \qquad (38b)$$

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satisfy the conveniently chosen boundary conditions

$$y_{I}(1) = 1; \quad y_{I}'(1) = 0$$

$$y_{II}(1) = 0; \quad y_{II}'(1) = 1$$
(39b)

The set of equations corresponding to (34b) is

$$\frac{d'' + \frac{d}{4\xi^2} - \frac{a\psi}{(1 - \beta \log_e \xi)^{\frac{1}{4}}}}{(1 - \beta \log_e \xi)^{\frac{1}{4}}}$$
(40b)

and the boundary conditions (36b) become

$$\phi_{I}(1) = 1 ; \quad \phi_{I}'(1) = 0$$

$$\phi_{II}(1) = 0 ; \quad \phi_{II}'(1) = 1$$

$$\psi_{I}(1) = \psi_{I}'(1) = \psi_{II}(1) = \psi_{II}'(1) = 0$$
(41b)

Solutions of equations (40b), satisfying the conditions (41b) were obtained for a fixed value of β and a set of values of the parameter

$$\alpha = \frac{12\mu\omega R_r^2}{P_{ro} H_o^2}$$

by means of a digital computer. Those shown in Figure A7-1, Appendix 7, correspond to the value of $\alpha = 0.093$.

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" e are now in a position to express numerically the derivatives

$$\frac{\partial Q}{\partial \rho} (P, R_{\rho}) = \frac{\partial_{\Gamma} (R) + i \psi_{\Gamma}(R)}{\partial_{\Pi} (R) + i \psi_{\Pi}(R)}$$

$$\frac{\partial Q}{\partial \rho} (P_{\rho}, R) = \frac{\psi_{\Pi}^{\prime} (R) + i \psi_{\Pi}^{\prime} (R)}{\partial_{\Pi} (R) + i \psi_{\Pi}^{\prime} (R)}$$

$$\frac{\partial Q}{\partial \rho} (r, r) = \frac{1}{\partial_{\Pi} (R) + i \psi_{\Pi}^{\prime} (R)}$$
(42b)

for discrete values of a.

Let the bearing geometry and the parameters P_{at} , P_{ro} , T_o , y and μ be specified. One may toen express the gap width, W_o , as a function of the supply pressure, P_s , by simply equating the outflow through the slot and the inflow through the nozzle. When explicit expressions are substituted for quantities which constitute the elements of the determinant (31b) and α is also specified, the only undetermined parameters are the recess depth, δ , and the supply pressure, P_s . In fact, the characteristic equation assumes the form:

$$a\left[\delta-\varepsilon_{1}\left(\alpha,P_{s}\right)\right]+ib\left[\delta-\varepsilon_{2}\left(\alpha,P_{s}\right)\right]=0 \tag{43b}$$

in which a and b are numerical constants. Therefore, given α , the problem reduces to finding specific values of P_{α} and δ , for which the real and imaginary parts of equation (43b) vanish simultaneously, e.g.,

$$\delta = g_1 = g_2 = \delta_c \tag{44b}$$

The experimental counterpart of this procedure is to maintain the ambient and recess pressures constant and to set the gap width by varying the supply pressure. The recess depth is then increased and its value on the threshold of instability is noted.

Critical recess depths and supply pressures were determined by trial and error. The method is illustrated by a numerical example in Appendix 4, and in the corresponding Figure A4-1 for $\alpha=0.050$. A plot of μ_1 and μ_2 against Γ_8 , showing the points of intersection of loci corresponding to $\alpha=0.093$, is contained in Figure 4. Results of the present analysis are shown and compared with those based on the lumped-parameter theory in Figure 5.

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3. Discussion of incaretical Pesults

The effect of varying several important parameters on the stability of the rectangular fearing is shown in Ligure 1. Here one finds reasonably good agreement between results based on the distributed and his ped-parameter theories, although the latter theory tends to predict values of allowable recess depth which are either conservative, when the pressure drop across the capply needle is relatively small, or slightly optimistic, when the pressure difference is discreased. The agreement is particularly good for values of the pressure parameter between 0.10 and 10.11, that is for pressure differences in the order of 10 psi.

he is seen that when the recess width is decreased by a factor of two, the allowable recess depth is nearly doubled, so that the critical recess volume remains essentially unaffected by a 12.5 percent increase in slot length. (Compare curves I and II in Figure 3.) Values of allowable recens depth, approximately twice as large again, may be obtained if the supply nozzle diameter is increased by a factor of 3. (Compare curves II and III in Figure 3.)

It is appropriate to remark at this point that decreasing the recess area and increasing the supply nozzle diameter have the adverse effect of lowering the load capacity and static stiffness of the bearing, so that stabilization is often a compromise in the selection of important design parameters.

A number of calculations were also carried out in order to investigate the effect of bearing Tass on stability. An increase in mass by a factor of ten showed that the effect was generally regligible for those rectangular geometries which were considered. The effect was greatest for the configuration corresponding to curve II. Figure 3, characterized by a relatively long slot and and a relatively small supply nozzle. At a value of the pressure parameter of approximately 0.04, for example, the tenfold increase in mass had the effect of reducing the allowable recess depth by 7.5 percent.

On the other hand, as shown in Figure 5, the mass had a significant effect in the case of the circular bearing geometry, particularly at low values of the pressure parameter. At $P_{\rm p} = P_{\rm ro}/P_{\rm p} = 0.13$, for example, an increase in mass by a factor of 3.25 resulted in a 50 percent decrease in the allowable recess depth. The deviation of results based on lumped-parameter theories was also significantly greater than for the rectangular configurations, particularly in the case of the smallest mass. (Curve III. Figure 5.)

The smaller the mass of a bearing, the greater the rate of response of the bearing tends to become. When the response rate is large, the gas in each volume element becomes partly trapped, rather than squeezed out. This, in turn, causes the film "stiffness" in the annulus to increase and permit greater "compliance" of a deeper recess without compromising stability. When the mass is large, the changes in pressure and density approach the quasi-static condition, and the foregoing effects are reversed. These two cases are illustrated diagrammatically and in an exaggerated manner in Figure 6 for the conditions of a heavily (a) and lightly (b) loaded bearing. In the circular bearing the surface corresponding to the annulus constitutes 96 percent of the total area and the olst converges toward the recess periphery where the gas density is highest. If the boundary motion is relatively maid, the gas cannot readily escape from the slot.

because of this, the influer * of mass on stability is more pronounced in the case of the circular bearing, as may be observed by comparing curves I. II and III in Figure 5. It can also be seen, that, as the mass increases, the agreement between results of the present and simplified analyses it proves, because changes occur nearly quasi-statically.

The simplified, lumped-parameter analysis is based on assumptions of quasi-static changes in pressure and was content and does not properly account for the effect of mass on the rate of response. In fact, when the inequality (A2-7), Appendix 2, is written explicitly:

$$\left(\frac{\lambda_3 + \lambda_5}{\lambda_0}\right) \left(\frac{\lambda_c}{m}, \frac{\lambda_1}{\lambda_3}\right) > \left(\frac{\lambda_c}{m}, \frac{\lambda_4}{\lambda_2}\right)$$
(45)

the quantity in cancels in the denominators on both sides, so that the stability condition is independent of mass. Though perhaps deficient from the quantitative point of view, the simplified, lumped-parameter analysis. Appendix 2, does give explicit relationships between other parameters which after the stability of the bearing. The inequality (A2-8), for example, can be written as a follows:

$$\frac{\left(\frac{\partial M}{\partial H}\right)_{\alpha}}{\left(\frac{\partial M}{\partial P_{r}}\right)_{\alpha}} > \frac{\frac{\partial}{\partial H} (R_{2} - R_{1})_{\alpha}}{\frac{\partial}{\partial P_{r}} (R_{2} - R_{1})_{\alpha}}$$
(46)

in which for a given bearing geometry.

$$M = f(T_o, P_{at}, P_{ro}, P_r, H)$$

$$(H_2 - H_1) = \mu(T_0, P_{at}, P_s, P_t, \Pi)$$

It follows that the stability condition also can be written as:

$$-\left[\frac{\mathrm{d}P}{\mathrm{d}H}\right]^{H} > -\left[\frac{\mathrm{d}P}{\mathrm{d}H}\right]^{H} = H_{0} = H_{0}$$
(47)

The physical interpretation of the above inequality is as follows. The left side of inequality (17) represents a change in recess pressure caused by a rapid change in gap width, each volume element acting as a closed cylinder in which the gas becomes trapped. The right side of inequality (17) represents a change in pressure caused by slow, quasi-static displacement, the annulus briving a flow-regulating, rather than gas-trapping effect.

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4. Conclusions and Summary of Theoretical Pesults

An analysis was made which treats the flow within the gas film in a thrust bearing on a continuous, rather than "lumped." basis. It shows that within the limitation imposed upon the design of the hearing by other considerations, the following parameters or combinations of parameters should be manifested or maximized in order to insure stability:

Missioned

- . Depth of pockets
- Difference between supply and recess pressures
- 3. I ffective mass of bearing

Vaximized

- 1. Supply auzzle diameter
- . 2. Tength of annulus
- 3. Area ratio of annular and pocket regions

One may also conclude from results of earlier, simplified analyses [2,3,6] which show good qualitative agreement with the present one, that high gas temperatures and adiabatic conditions favor stability.

The most important factor influencing the stability of externally pressurized bearings is the interaction of the total gas-storage capacitance with the flow-regulating characteristics of a fixed supply restrictor and a variable annulus. The ratio I, mg. where I, is the load and m the mass of the bearing, also influences stability. Deeper pockets can generally only be tolerated for very moderate pressure drops across the supply nozzle. The limiting depth increases with the nozzle diameter and decreases with the length of the annulus, as well as with the mass of the bearing. Those trends are illustrated in Figures 3 and 5.

The advantage of recessed pockets, channels, or grooves is that they increase the load capacity and static stiffness. The recess perimeter also provides a larger area of admission into the annulus, thereby reducing entrance velocities and preventing shocks [19, 20, 21]. These advantages, however, must be weighed very carefully in the light of requirements dictated by stability conditions.

IV. EXPERIMENTAL APPARATUS

1. Design of Experimental Apparatus

The main objectives in designing the test apparatus were the following:

- a). To insure maximum flatness and rigidity, as well as hardness and material stability, of the thrust plates.
- b) To provide means of precise alignment, and of accurate methods for checking the parallelism and separation of the bearing surfaces.
- c) To restrain the mode of oscillation to an axial direction with minimum friction.
- d) To place a variable-volume, leak-proof cavity in the center of one thrust plate and to provide for precise adjustment and accurate measurement of its depth.
- e) To lumish means of applying a constant, non-massive, axial load which would not be affected by the motion of the bearing.
- To design for maximum rigidity of the entire structure for the purpose of minimizing deflections and preventing a condition of system resonance within the anticipated frequency band width of oscillations.
- g) To provide sensitive vibration pick-ups and associated electronic and photographic apparatus in order to detect, measure—and record amplitudes of oscillations which are small in comparison with the magnitude of the equilibrium gap width.
- b) To furnish a well regulated, relatively clean and moisture-free air supply. To select reliable pressure gauges, manometers and flow meters for the purpose of determining the static characteristics of the test bearing.

The test bearing assembly drawing is shown in Figure 7. The sturdy construction of individual parts and of the entire structure, particularly the plates and columns, is self-evident. All members were machined to extremely close tolerances, subjected to proper heat treatment and inspected prior to, during, and after manufacture and assembly. The upper thrust plate 1 fould be aligned 1 me ins of three 2 inch diameter, 48 threads per inch, adjusting screws 2 and securely bolted to the supporting columns 2. The lower thrust plate was integral with the shaft 2. Both thrust faces were chrome plated and lapped flat to the order of 1-1/2 interference bands of monochromatic sodium light (approx. 20 x 10⁻⁶ inches). Final inspection, using 6 inch diameter optical flats, showed that the convexity of a symmetric and almost circular central region of both plates did not exceed one interference band up to approximately four-fifths of the 5 inch diameters. Three sensing probes 4 of an air gauging system, incorporated in the upper plate, were equally spaced along the perimeter of the thrust face and lapped together with it.

An exact determination of deflections and modes of vibrations of the thrust plates was not attempted because of the complexity of the problem involving thick plates, supported in a manner described in the foregoing. A conservative estimate, based on approximate plate theory, the

[†] Circled numbers correspond to those in Figure 7 and refer to assembly components.

assumption of simple support along the column pitch circle diameter and a concentrated 500 lb. look showed that the deflection of the center of the upper thrust plate with reference to its edge was of the order of 20 x 10.00 inches. The deflection of the lower thrust plate, in which the cantilectrifie, overloop ring was subjected to pressures which in that region approached the ambient value, would be negligible in comparison. It was concluded, therefore, that load deflections would have a compensating effect on the slight, initial convexity of the surfaces.

The theory of vibrations of plates, even in approximate form, is very complex. On the assumption that the frequency, p₁, of the lowest mode of vibration could be estimated from the countries [58]:

$$p_1 = a \left(\frac{Et^2}{12t^4p(1-v^2)} \right)^{1/2}$$

in which a is a constant depending on the method of support. E is Young's modulus, ρ the Poisson's ratio, ρ the mass density of the metal, r and t the radius and thickness of the plate, the lowest frequency was estimated to be of the order of 10^4 radians per second and, consequently, considerably higher than the anticipated frequency band width of auto-oscillations.

The upper thrust plate, Figure 8, contained a centrally located recess, the depth of which could be varied by means of a sliding piston 12 and a micrometer adjusting screw 15. Three tightly fitted "O" rings served as sliding seals. The piston could be locked in any desired position and the recess depth varied from zero to 3/4 inches. Air was supplied through a 7-16 inch diameter, drilled duet in the upper plate. It flowed into a chamber, the volume of which comprised the scaled space between the "O" rings and the bore of the piston, Figure 9. The flow restriction between this chamber and the recess was effected by means of a short, bell-mouthed, 0.055 inch diameter nozzle (8).† The drawing of an auxiliary piston (Figure 10), shows a 0.0135 inch diameter pressure tap, located at 11-32 inches from the piston center. The tap was connected through an internal duct to a gauge which indicated the static, equilibrium recess pressure at that point. In the modified version of the piston, the pressure tap was centrally located and plugged when dynamic tests were conducted.

The drawing of the shaft and lower thrust plate is shown in Figure 13. The shaft was hollow so that the movable mass corresponded to 25 lbs. The weight could be increased to 45 lbs. by attaching a 20 lb. bronze disc to the shaft, midway between the 3 inch journals. (It will be recalled that theoretical stability loci were constructed for masses corresponding to weights of approximately 13.9, 25 and 45 lbs.) Rigidity requirements, however, procluded a less massive shaft and thrust plate construction and no provision could be made to obtain experimental data for the smallest mass. The 3 inch diameter, a reular area of the plugged end of the shaft provided a surface exposed to the pressure of the loading cylinder (20) by means of which the thrust load was applied to the bearing. Impulse turbine buckets were milled in the shaft to provide a high speed drive for experimental work involving rotation which could be conducted upon the completion of

In a modified, later version of the piston, provision was made for replacement of a single restrictor by 4, 0 or 12 nozzles. In each case the total cross-sectional throat area was adjusted to give approximately calculated rates of mass flow (see Figures 11 and 12).

this phase of the investigation. The size, concentricity, roundness and taper of the shaft journals were found to full within tolerances specified on drawings. The total indicated runout of the thrust face with respect to the journals, measured on a 5-3/4 inch diameter, was less than 0.0002 inches. The shaft was balanced to within 0.00025 inch-pounds.

The problem of restraining the motion of the shaft and the lower thrust plate to a purely axial direction by means of low-friction guides was solved by mounting the shaft in externallypressurized, air-lubricated journal bearings 23 . There were two main reasons for this type of lateral support. First, the analysis was predicted on the assumption that external damping was negligible, since primary interest was only in those stability parameters associated with the bearing itself. Secondly, from the practical point of view, it was desirable to simulate as far as possible a method of gas bearing support which could be eventually applied to small turbines, compressors or centrifugers. A drawing of one bearing is shown in Figure 14. The main feature of the design was a set of six, grooved, centrally located and equally spaced pressure pads. Air was supplied to the pads through 0.016 inch diameter, brass orifices 25), shown is Figure 15. The purpose of the grooves was to minimize the storage volume of each pad, while extending a relatively uniform, high-pressure area to the outer perimeter of the grooves. The net effect of this arrangement contributed to the stability of the bearing and produced a steep toad-deflection characteristic, Figure 16. Needle valves (26) were placed in drilled air ducts leading to alternate pads. The function of the needle valves was t allow for controlled misalignment of the shaft within the limits of the bearing clearance. By varying the pressure in individual puds, an excellent method of making final adjustments in the alignment of the thrust surfaces was provided, furnishing improvement on the high degree of parallelism already achieved by means of the levelling acrows:

The bearings were dowel-pinned and bolted to the supporting members prior to final machining, during which both bearings and the sleeve of the loading cylinder were ground to size in one operation. The grinding operation was performed with a degree of precision which made it possible to span all three bores with a single plug gage, barely 0,0003 inches smaller than the minimum, measured bearing diameter. All grooves were indicated on the grinding machine and their depth varied from 0,006 to 0,007 inches. The orifice inserts, needle valves and the ennular supply chamber of the bearing were sealed by means of "O" rings.

It were estimated that a bearing stiffness^{††} of 3 x 10⁵ to 5 x 10⁵ pounds per inch could be realized when the journal was in the concentric position. With the bearings and the shaft assumed as a spring-mass system having two degrees of freedom, approximate values of frequencies of natural modes of vibrations were calculated by considering a pivoting motion of the shaft about one bearing, the other journal being acted upon by a spring. The "constrained" frequencies, p, are given by [58]:

$$p = \ell \left(\frac{k}{l_c + m \ell_c} \right)^{1/2}$$

[†] The grooves at the end of the shaft were intended to suppress instability (whirl) due to hydrodynamic forces in the clearance of the loading cylinder sleeve.

ff'The slope of the load-deflection curve is sometimes referred to as the "stiffness" or more correctly, as the "static stiffness". (See Figure 16.)

in which t is the span length between the bearings, 4 the distance from the chosen pivot to the center of gravity of the shaft, k the stiffness, m and L the mass and moment of inertia of the shaft about its renter of gravity. The estimated natural frequencies for the 25 lb. shaft were in the order of 3×10^3 and 5×10^3 radians per second and could be substantially reduced, or raised, by varying the supply pressure. It was concluded, therefore, that in the absence of appreciable unbalance and moments in planes passing through the shaft axis, the pitching motion of the shaft within the clearance of the journal hearings would be relatively small in comparison with the ampirtude of axial oscillations.

The loading cylinder (20) consisted of a 7-1-2 x 3-1-2 inches pressure vessel attached to the lower end of the supporting structure. A constant pressure maintained in the cylinder and acting on the end of the shaft protruding through the cylinder sleeve, balanced the load applied to the lower thrust plate. For small amplitudes of oscillation, volume changes would be negligible in comparison with 155 rabic inches of cylinder displacement. The cylinder pressure would remain essentially constant, unless the frequency of oscillation produced a condition of accoustic resonance in the chamber, in which case the shape and volume of the cylinder could be altered accordingly. The cylinder provided a simple method of applying a constant, non-massive load to the test bearing.

The lower ends of the 3 inch diameter or humas of the test rig were press-fitted into a 2 inch thick plate (9) in which one of the journal bearings was mounted. The upper ends of the columns were located and holted to a similar plate (3) containing the second journal bearing. The column locating holes in both plates were jig bored in random. The concentricity and squareness of the columns and locating bosses were indicated from the head of the precision grinder after the hearings and the hore of the loading cylinder slocks were finished to size. The assembly was bolted to a massive and very rigid tripod. The weight of the entire structure was approximately 750 lbs. In the course of experimentation it was found necessary to interpose relatively soft isolators between the tripod and the foundation floor. The reason for doing so is discussed later in the text. A schematic of the air supply system is shown in Figure 17. Photographs of test apparatus, its components and of auxiliary equipment are shown in Figures 18 through 25.

2 Instruments - Performance and Calibration

a. Air Gauges

The threefold function of the air gauging system, briefly referred to in the foregoing section, was (a) to facilitate the alignment of thrust surfaces to a high degree of parallelism, (b) to measure the equilibrium gap width, Ho, and (c) to provide a quick and direct method of calibrating the primary capacitance probe without disturbing its initial position and offset.

The well-known method of measuring small displacements in terms of pressure utilizes two flow restrictors, placed in series, a constant, well regulated pressure source and suitable pressure indicators. Air enters an intermediate chamber from a constant pressure reservoir through a small, fixed (or adjustable) orifice. The variation of pressure in the intermediate chamber is recorded and depends on the supply pressure level, as well as the relative size and flow characteristics of

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the restrictors. The cross-sectional flow area of the second restrictor is made to vary with displacement, so that resistance to flow is farmished by a slot, or a circumferential orifice formed between the surfaces of the sensing probe and the displaced member.

For a fixed orifice size, the slope and curvature of the pressure-displacement characteristic depend mainly on the size and geometry of the probe restriction, and on the magnitude of the supply pressure. The characteristics are nonlinear and exhibit an inflection point, in the neighborhood of which the amplification is highest. The probe can be made in the shape of a short, thinswalled or a tnick-walled cylinder. In the latter case, the restriction between the probe and the displaced member has the form of a narrow, redial slot rather than that of a circumferential orifice. All other factors being equal, a slot-like, variable restrictor produces a higher sensitivity, though at some expense of linearity in the pressure-displacement characteristict. This effect is due to a more pronounced influence of viscous borces in a narrow slot than in a circumferential orifice.

It was considered that a low supply-pressure gauging system, integral with the upper sheast plate, would have an advantage over commercially available units, which generally operate at supply-pressure levels of thirty to sixty pounds per square inch. The system was to be ensured into the test rig assembly, with probes rigidly mounted in the upper thrust plate and lapped in the plane of the thrust surface. A well regulated supply head of two to three feet of water could be obtained by means of a standpipe, with the excess air in the supply reservoir being allowed to escape at the end of an immersed tube. It was also desirable to avoid the impingement of relatively high velocity probe jets associated with high pressure systems, since this impingement might have involved difficulties in calibration, and possibly minor effects of heat transfer on the accuracy of measurement.

An estimate of orifice and probe dimensions for a low pressure system was made by assuming the flow to be incompressible. Dimensionless pressure-displacement characteristics were obtained by equating the inflow through the orifice to the outflow through the probe restriction, confidered either as (a) a narrow, radial slot or (b) a circumferential orifice. Results of these preliminary calculations used in establishing approximate values of design parameters are shown in Figure 26, which also contains a schematic of the supply head regulator.

The effect of changes in barometric pressure on gap width measurement could be estimated from equations (8) and (9), the flow through the orifice and probe restrictions being essentially analogous to that through the bearing supply nozzle and gap. The gap width is then given by

$$H_o^3 = K \frac{(P_s P_{ro} - P_{ro}^2)^{1/2}}{P_{ro}^2 - P_{ro}^2}$$

[†] The principles involved in the community the pressure-displacement characteristic of an air gauge are essentially similar to there which apply to load-displacement characteristics of externally pressurized, gas bearings.

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in which Γ_{a} , P_{ro} and P_{at} now refer to the absolute values of the supply, intermediate and ambient pressures of the air gauge system, and K is a constant. Taking the logarithm of both sides of this expression and differer fixting, the approximate error in gap width measurement, associated with a change of $\pm \Delta P$ in barometric pressure, is:

$$\frac{\Lambda H_0}{H_0} \simeq \mp \frac{\Lambda P}{6P}$$

where in the last step it was assumed that the pressure differences are sensibly small, e.g., $P_{x} = P_{x0} = P_{at} = P$. A change of \pm 0.5 psi, relative to the barometer reading during calibration, would cause an error of \pm 0.5 percent in the measured gap width, less than 10 microinches.

Initial difficulties were encountered because of supply pressure fluctuations caused by the surface tension of bubbles, forming and breaking away from drillings at the immersed end of the tube. This was circumvented by inserting a damper in the form of a series of perforated discs in the reservoir end of the tube and reduced the ripple to an almost imperceptible magnitude, relative to the smallest manometer scale reading or 1 '10 of an inch. The supply pressure was adjusted to a steady, constant value of 39.2 inches of water by varying the setting of a fine, long taper needle valve.

The calibration was performed in steps of 0.0001 inches over a gap width range from 0.001 to 0.002 inches. Square, 1 x 1 inch precision gauge blocks, having a dimensional and parallelism telerance of 1 microinches, were used for this purpose. Two blocks, differing in thickness by a multiple of 0.0001 inches, and a third block were wrung together. The step gauge created in this fushion was then wrung together with the lapped thrust surface, the step extending from the edge of and overlapping the entire probe diameter. (See schematic in Figure 27.) The probes were spaced 120 degrees apart and located 1/4 of an inch from the edge of the upper thrust surface. The blocks were taken apart and reassembled after each round of manometer readings for all three probes. This was repeated 21 times for each probe and everyone of the 11 calibration points, a total of 691 manometer readings. The gauge blocks were assembled at random and it was reasonable to assume the arithmetic average of 21 manometer readings as the most probable value corresponding to the nominal dimension of the step gauge offset. The curvature of the pressure-displacement characteristic in the experimental range of gap width was very slight. The maximum difference in any set of 21 manometer readings was less than 0.4 inches of water. At a representative sensitivity of 0.15 inches of water per 10^{-5} inches displacement, this was equivalent to $2.7 ext{ x } 10^{-5}$ inches, or less than 3 percent of minimum gap width in the experimental range. Leastsquare-fitted calibration curves, Figures 27, 28 and 29, were considered adequate for gap width measurement to an accuracy of 1 to 2 percent.

b. Vibrometers - Primary and Auxiliary Probe Systems

The validity of assumptions made in the analysis increases if the amplitude of motion is small in comparison with the equilibrium gap width. For reasons arising from practical considerations, such as the impossibility of insuring perfect isolation, ideal rigidity of structural members, absolute steadiness of air flow etc., the feasibility of detection and, above all, meaningful interpretation of amplitudes in the order of 10°0 inches was doubtful. It was arbitrarily decided, therefore to regard amplitudes of oscillation in the order of one percent of the gap width, or to 10°5 inches, as small.

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The function of each probe system was to interpret dynamic capacitance changes in terms of relative displacement of the probe and the vibrating member. The primary probe system, shown on the left side of Uignre 30 was used in me parting the axial oscillations with which the experiment, were bainly concerned. The auxiliary probe system, shown on the right side of Figure 30 couples ed in after capacitive pick-up, which could be mounted in several positions along and around the shaft. The function of the auxiliary probe was to detect transverse modes of vibrations which ought be coupled with the axial notion of the shaft. It was, of course, desirable to reduce this motion to a bare minimum and the air-lubri ated on the hearings were designed with this objective in mind. The auxiliary system thus played a monitoring role in the course of experimentation. The operation of these vibrometers was based on different principles. Their operation, performance and calibration are described in the next paragraphs.

In the schematic magrin, of the primary instrument, a Fielden Proximity Meter, model TM-951-1, the variable probe capacitance, C., is shown shanted across one of the two balancing capacitors of an impedance bridge. The source of bridge excitation was a 450 K.C. oscillator (modulated by 2.4 ke when using the meter for static measurements). The out-of-balance voltage of the bridge was applied in succession to the tube grids of a two-stage, radio frequency amplifier. The gain of the amplifier could be controlled by a variable, tapped resistor in the cathode circuit of the amplifier tubes by means of a six-position switch, providing an attenuation up to 50 decibels in steps of 10 decibels. The bridge could be balanced by means of capacitors, C, and C,, and the potention eter II, which balanced the probe lead resistance. The frequency response of the instrument, Figure 31, was flat from D.C. to approximately 1200 cps and, therefore, more than adequate for measurements in the anticipated 100-400 cps band width. The output of the instrument was applied to one pair of terminals of a dual trace preamplifier of the cathode ray oscilloscope. The preamplifier had nine sensitivity settings in the range of 0.05v am to 20v cm and a variable vernier adjustment. The frequency response of the oscilloscope-preamplifier unit (Tektronix, type 532, and dual-trace preemplifier, type 53-540, was 3 decibels down at 5 megacycles, considerably higher than that of the hielden instrument.

The primary peaks, Figure 24, consisted of a 1.4-inch diameter, brass disc, mounted in an insulating sleeve. The disc are sleeve assembly were pressed into the opening of a 4.5-inch long probe holder and lapped square with its axis. The body of the holder, which also served as part of the outer shield was rigidly chapped to the upper thrust plate by means of a split collet and a gripping clamp. With the radio frequency amplifier control adjusted to approximately one third of movimum gain and a preamplifier vertical deflection setting of 1 volt per centimeter, the sensitivity corresponded to 1 centimeter vertical deflection per 10⁻⁵ inches displacement when viewed on the display of the cathode ray oscilloscope. The observed noise level and drift at this setting, after an initial, one hour warm up period, was of the order of 0.05 to 0.1 volts. The maximum room temperature variation during any 10.21 run was between 74 and 77 degrees Fahranheit. The probe lead was double-shielded to prevent stray voltage pick-up and relatively short, in order to minimize capacitance in parallel with that of the probe. For this reason also, the thickness of the insulating sleeve (dielectric constant of 2) was 0.1 inches and, therefore, large in comparison with the initial, 0.003 and offset between the 1.4 inch probe disc and the lower thrust plate.

Following the parallel alignment of thrust surfaces, the probe was calibrated in three positions, corresponding to approximately the end and midpoints of the experimental range of gap widths. The calibration was performed, using the air gauges as a standard. The calibration

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curves are shown in Figures 32, 33 and 34. From their appearance it could be concluded that for amplitudes of displayement in the order of 1×10^{-5} inches to 2×10^{-5} inches, no large error would be incurred by assuming linearity in the neighborhood of null points and a sensitivity value of 1 volt per 10^{-5} inches displacement.

The schematic diagram of the auxiliary instrament (Decker, Delta Unit 902-1 and Monitor 1 nit 902-2) shows the capacitance probe, $C_{\rm v}$, mounted in one of the positions along the shaft. The main component of the system was a tube, containing gas† under reduced pressure. The tube was placed between two external electrodes connected to a 250 KC oscillator. The excitation claused a luminous discharge, so that the two internal electrodes of the tube were in contact with the plasma of the ionized gas. Any asymmetry in the spacing of the electrodes would give rise to a potential difference between the internal electrodes, caused by the migration of electrons. The effect of asymmetry could also be produced by changing the magnitude of the sensing capacitor, $C_{\rm v}$, relative to the balancing capacitor, $C_{\rm o}$, both shown in the schematic diagram of Figure 30. The operation of the auxiliary probe, $C_{\rm v}$, was based on this principle [62]. A cathode follower provided a low impedance output at the preamplifier terminals and a filtering network eliminated the fraction of oscillator excitation passed through the transducer.

The transducer, probe, mounting bracket and calibration fixture are shown in Figure 25. The probe and the balancing capacitor were mounted very close to the internal tube electrodes and all leads were relatively short in order to minimize the adverse effect of stray capacitances on the output and frequency response of the instrument.

The frequency response of the auxiliary instrument, Figure 31, was flat to approximately 300 cps. 0.5 decibels down at 400 cps and, therefore, quite adequate in the anticipated, experimental frequency band width. The calibration curve of the auxiliary probe, Figure 35, displayed a greater degree of nonlinearity than that of the primary probe. The sensitivity in the neighborhood of the null point was approximately 0.02 volts per 10⁻⁵ inches displacement, representing 0.4 centimeters vertical deflection per 10⁻⁵ inches displacement on the cathode ray oscilloscope display at the highest preamplifier sensitivity setting of 0.05 volts per centimeter. The observed noise level was of the order of 0.005 volts. Since the maximum sensitivity of the auxiliary probe was considerably less than that of the primary, the monitoring test of lateral shaft vibrations was conducted under conditions of axial oscillations approximately twenty times as large as the amplitudes of self-excited vibrations observed in the course of stability experiments.

c. Pressure Gauges, Flowmeters and Regulators

The supply, recess and loading piston pressures were measured by means of two, dual bourdon tube construction, eight and one half inch dial diameter, absolute pressure gauges. The gauges were graduated in steps of 0.1 and 0.2 psi over their respective ranges of 0-100 and 0-150 psia. The ranges were covered in approximately two revolutions of the pointer. The scale had a mirrored surface reflecting the fine blade of the pointer to eliminate parallax errors and the size of the smallest subdivisions permitted reliable estimates of readings to the nearest 0.05 psi. The pressure gauges were calibrated by the manufacturer by means of a precision mercury barom eter, a duplicate of a Bureau of Standards reference barometer. The accuracy of the pressure

[†] Argon or Neon

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gauges was guaranteed to be within 0.02 percent of full scale deflection, representing 0.027 percent for the 0-100 psia gauge and 0.041 percent for the 0-150 psia gauge at 73.5 psia, the lowest test reading. The scales were hand drawn to match over one hundred calibration points. The hysteresis, backlash and "dead zone" of the pressure gauges vere entirely negligible. As an additional check, the gauges were connected to the same pressure source and their readings compared. No perceptible difference was observed in the range from 50 to 100 psia.

Flow measurements were performed, using a variable area flow meter (rotameter) in conjunction with a calibrated, bellows type gas meter. The position of the rotameter float was registered along the scale of the 600 millimeter long tube for any particular setting of the bearing supply pressure. With this setting maintained and the position of the rotameter float unchanged, the flow was diverted to the gas meter. The totameter thus merely reved as a secondary, indicating instrument, while the actual flow rates were determined from the gas meter readings. The calibration of the gas meter was performed by means of an inverted-tank-type gasometer of 20 cubic feet capacity, used as a standard by a local utility company. Five calibration runs were made after the final adjustment of the counter mechanism, at a representative bearing flow rate of 5 cubic feet per minute, referred to standard atmospheric conditions. (Approximately four revolutions of the five cubic foot counter.) The differences in the final positions of the gasometer displacement indicator were negligible in comparison with the total displacement. The speed of the counter, approximately one revolution per minute, was slow enough to enable the observer to estimate the position of the pointer, relative to a predetermined mark, at least within 6 degrees, or better. This, in terms of displacement, corresponded to approximately 0.5 percent of the gasometer volume.

The astameter float was operated in the upper half of the tube. Slight oscillations of the float were observed in the uppermost tube region, but their peak-to-peak amplitudes were of the order of 2 to 3 millimeters, as compared with the 600 millimeter length of the tube. An estimate of 2 to 3 percent accuracy in flow measurements obtained in the course of experimentation appears to be reasonable.

The pressure regulators used in the test-bearing air-supply system, Figure 17, were capable of maintaining a downstream pressure setting within 0.1 psi over their entire flow range and a 25 psi variation in delivery pressure. One regulator was installed ahead of a 7.5 cubic foot air storage tank and individual regulators were placed in the supply lines leading from the tank to the loading cylinder, test and guide bearings. The performance of the regulators was most satisfactory and pressure settings could be accurately maintained, with drift not exceeding 0.05 psi over periods of two to three hours.

V., EXPERIMENTS

1. Static lests

the calibrated air gauges furnished the cleans of bearing surface alignment. The 25 lb. shall was inserted in the pressurized guide bearings and the upper thrust plate placed on the colman locating basses. The concentricity of the hearing members was checked and adjusted to within 0,001 inches. The first surfaces were then brought into parallel alignment by means of levelbing screws and air gauges and secured to the columns. As an additional check of parallelism, the following test was performed. A spacer, approximately 1.73 x 10-3 inches thick, was lightly champed between the thrust surfaces at twelve, thirty degree, angular intervals along their perimeter. Manometer readings of one air gauge only were registered for each position. This was repeated nine times and the mill metic average of readings for each position was taken. An identical test was carried our with a spacer 1.53 x 10⁻³ inches thick. In the process of sampling, the spacer was clamped by a constant, 0.5 lb, force, at an average distance of two inches from the bearing center. The guide hearings, spaced nine inches apart, were pressurized and their stiffness in the concentric position. Figure 16, was in the order of 1 x 10-5 pounds per inch per bearing. Any misalignment, therefore, caused by the moment of the small clamping force, would be negligible. The results of this alignment test are shown in Figure 36, in which the circularly spaced numbers refer to average manometer readings of gauge No. 1 obtained with both spacers. By reference to the calibration curve in Figure 27, it can be seen that the thrust surfaces were parallel within one percent of the equilibrium gap widths, that is inclined under an angle in the order of 4×10^{-5} degrees. * The shaft thrust face had a total indicated runout of 0,0002" relative to the journals and the alignment would have been destroyed, had the shaft Seen allowed to drift in its guide bearings. An additional constraint, therefore, was furnished by means of two opposed and narrowly spaced air jets, impinging on a light, thin fin, attached to the shaft collar. (See Figure 18, for example,) The alignment was thus performed with the shaft maintained in the same position relative to the guide bearings.

The analysis was based on the existence of an essentially uniform pressure plateau, extending over the entire, one inch diameter recess area. It was postulated that, as long as the recess depth remained relatively large, the effects of the air jet issuing from the 0.055 inch diameter nozzle and the acceleration of the fluid as it entered the slot would be local and detract little from the recess volume conceived as a constant pressure reservoir. Since the stability boundary for critical recess depths in the order of 10^{-2} inches was of particular interest, the question which presented itself was the degree to which the foregoing suppositions were valid for recess depths smaller than the nozzle throat diameter and comparable in magnitude with the bearing gap width. The following possibilities deserved careful consideration. (a) For $\delta > 1$ ± d $_{\rm V}$, the cylindrical area bounded by the nozzle diameter and its projection on the lower thrust surface would replace the nozzle throat as the controlling restriction. (b) The recess, its depth sufficiently reduced, could act as an inward extension of the bearing gap and virtually cease to function as an intermediate reservoir. (c) The accelerating flow in the diverging region adjoining the nozzle exit could attain supersonic velocities, followed by shock and a transition to the predominantly viscous flow

Interference fringes observed under optical flats indicated that each 1.5 x 10⁻⁵ to 2.0 x 10⁻⁵ plate convexity was quite concentric and approaching in shape that of a surface of revolution. Parallelism, or inclination, therefore could be thought of in reference to the circular bases of those elevations.

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region in the slot [19, 20, 21], a situation analogous to that which might exist in a duct fed by a converging diverging nozzle.

A test was conducted, in which the load and a representative value of the supply pressure. 67.5 psia, were held constant, while the recess was being reduced in depth from a relatively large value. The objective of the test was to determine the "cut-off" point, at which any further reduction in depth would cause a change in the steady-state flow pattern and pressure distribution. This would then be recompanied by an easily detectable and measurable departure from the initial gap setting. Results of this test, presented in Figure 37, indicate that, for a centrally located, 0.055 inch diameter nozzle, the "cut-off" point corresponded to a recess depth of 0.030 inches.

Since the critical stability parameter was the volume, rather than the depth of the recess, the first, successful attempt at a remedy was to surround the nozzle exit by a 0.375 inch diameter, 0.026 inches deep cavity (see Figure 22). This, however, did not provide an entirely satisfactory solution, since for small critical volumes the delineation between slot and recess became rather vague. For this reason, and because the linear dimensions of the restrictor influence the degree of uncleadiness in pulsating flow, the pistons were replaced by modified varsion, Figure 11, which incorporated interchangeable, multiple-nozzle plates. The plates, Figures 12 and 23, contained either four, nine, or twelve short, bell-mouthed nozzles, equally spaced on a 0.5 inch diameter circle. Their total, cross-sectional throat area was later adjusted to give a flow characteristic approximating the calculated one within the experimental range of pressure ratios. The twelve nozzle plate was used in the concluding experiments. At a supply pressure of 87.5 psia, a reduction in recess depth from 0.008 inches, the "cut-off" point, to 0.006 inches, was accompanied by a decrease in gap width in the order of two percent only. The effects of decrease in recess depth on gap width for single and multiple nozzle feeders are compared in Figure 37.

The calculated load capacity of the test bearing, based on the assumptions of laminar flow in the clearance, negligible entrance effects and uniformity of (cessure in the recess, varies almost linearly with the recess pressure and is independent of the supply pressure.

In order to ascertain the extent to which the actual conditions conformed to this idealization, a test was conducted in which (a) the load was adjusted to maintain a constant recess pressure to 73.5 psia, or (b) the load was held constant at the calculated value of 472 lb, and the recess pressure to was allowed to seek its own level. The result of this test is presented in Figure 38 and indicates that in case (a) an increase of the supply pressure to 95 psia was accompanied by a 5 percent reduction in load capacity, whereas in case (b) a 4 percent increase in recess pressure was observed. Throughout this test the recess depth was larger than the "cut-off" value, referred to in the preceding paragraphs.

The desirability of minimizing differences between the actual and theoretical, steady-state bearing characteristics was of considerable importance with reference to the mass flow rate, since its partial derivatives with respect to gap width and pressure, equation (16b), played an important role in establishing the limiting values of stability parameters. Preliminary flow measurements indicated, that in the experimental range of pressure ratios the overall discharge coefficient, using a

[†]Pressure tap centrally located. Recess depth $\delta \geq 0.010$ inches.

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twelve nozzle supply restrictor, varied approximately from 0.78 to 87. The total throat area was then increased by approximately 10 percent, in order to narrow down the gap between actual and calculated flow rates.

Mass flow rates were determined in the range of supply pressures from 75 to 95 psia, with a constant load of 472 lb., the calculated value corresponding to a recess pressure of 73.5 psia and ambient pressure of 14.7 psia., applied to the test bearing. (A condition analogous to that under which stability tests were conducted.) The recess depth was always maintained at a value greater than the "cur-off" point referred to in the preceding paragraphs. The mass flow rates in the experimental range of supply pressures, obtained with slightly increased nozzle diameters, were 94 to 97 percent of the calculated values, while deviations of measured gap widths were in the order of one percent. Results of mass flow and gap width measurements are presented in Fig-

the order of one percent. Results of mass room and g=r ures 39 and 40. The corresponding bearing Reynolds number, $N_{R}=\left(\frac{\rho_{T}\Gamma_{r}H}{\mu}\right)_{o}=\frac{W_{o}}{2\pi\mu\Omega_{T}}$ is

given in Figure 41. Mass flow rates and the Reynolds number obtained in a supply pressure range for a bearing load of 222 lb. and corresponding to a stability test conducted under reduced load conditions are given in Figures 42 and 43.

It seemed highly unlikely that absolute, one-to-one correspondence between calculated and actual, steady-state values of pressure, gap widths, and flow rates could be simultaneously achieved throughout the experimental range. It was considered that, in the presence of slight deviations in several static bearing characteristics from those of the idealized model, a fair compromise was reached, and that the deviations were of a reasonable order of magnitude.

2. Preliminary Stability Tests

Initial differences in calculated and actual, static bearing characteristics and subsequent modifications incorporated in the apparatus, were described in the preceding section. These modifications, and a number of additional changes, were also dictated by evidence gathered from results of simultaneously conducted, preliminary, dynamic tests. The preliminary tests furnished considerable information, of interest in itself, and useful from a practical point of view. In this section an account of preliminary experiments is presented in a logical sequence, not necessarily in the order in which they were conducted.

The dynamic experiments, with the exception of one comparison test, in which the recess pressure†† was held constant, were conducted under constant load conditions. Results of static tests indicated that, in the latter case, deviations from predicted, static bearing characteristics appeared to be less pronounced. Moreover, since the recess pressure could be measured at one point only, there remained the uncertainty of its distribution in the entire recess region, whereas, on the other hand, the load could easily be set and held constant at a predetermined value.

 $\dagger\dagger$ As measured by a tap located at a radial distance of 0.344 inches from the center.

[†] Flow rates were calculated for a 0.055 inch diamets, nozzle. The single nozzle was replaced by twelve nozzles and their diameters were enlarged from 0.0159 inches to approximately 0.0167 inches.

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The tests were conducted in the following manner. The load was applied to the bearing and the supply pressure adjusted to a predetermined value. The recess depth was then increased for decreased quasi-statically, until the bearing became unstable. In certain cases the procedure was reversed, e.g., the recess depth was set and the supply pressure increased (or decreased) very gradually, up to the threshold of instability. The axial oscillations were detected by the primary capacitance probe and viewed on the display of the cathode ray oscilloscope. Photographic records of amplitudes and frequencies of oscillations were made for a number of runs. A simultaneous check on previously determined, steady-state flow rates and gap widths was made for points in the immediate vicinity of the stability boundary. The boundary was always approached by preceeding from the stable region to the unstable region.

The first, preliminary stability test was performed, using a plane-faced pi-ton and a centrally located, 0.055 inch diameter supply nozzle. Results of this test are shown in Figure 44. The abrupt transition in the lower branch of the cueve, associated with the reduction in recess depth below the "cut-off" point (see Figure 37), provided yet another, valid reason for modifying the piston and, finally, replacing the single nozzle feed by a multiple-nozzle supply system. The upper branch of the stability boundary constituted a marked departure from the predicted, single-valued locus. This trend persisted in all subsequent experiments.

Figure 45 contains results obtained with a modified piston, having a secondary, fixed volume recess, but retaining a single, centrally-located supply nozzle. It can be seen that the unstable region carclosed by the curve corresponding to a constant load test was smaller than the unstable region bounded by the locus obtained when the load was adjusted in order to maintain a constant pressure at a tap, located 0.334 inches from the recess center. Both curves were marked by the absence of the sharp transition observed in the case of the plane-faced piston*, but continued to display two characteristic branches, separated by the point at which their slopes became infinite.

A secondary stability experiment was conducted in parallel with previously described. static tests, the objective of the latter being to assess the reliability of the assumption that the recess pressure at constant load was not appreciably affected by changes in the supply pressure. It was observed that when the 0.0135 inch diameter, 0.125 inch long pressure tap (see Figure 10) connected the recess to a relatively large, closed volumett, an effect, which could justly be described as hysteresis, was present. With the bearing stable at a particular setting of supply pressure and recess depth, the supply pressure was increased very slowly and gradually, particuhar care being exercised to avoid disturbances which might be large in comparison with those randomly produced and always present in the fluid, foundation and the surrounding atmosphere. Under those conditions it was possible to increase the supply pressure considerably above the value at which the bearing became unstable if jarred, displaced or subjected to a sharp impact in the axial direction. The supply pressure was then reduced to a level at which the bearing became stable again. At this level, instability could no longer be induced, regardless of rate and magnitude of the disturbance. Identical effects could be observed with the supply pressure held constant and the recess depth being varied quasi-statically. With an isolated recess volume (e.g., closed pressure tap), no hysteresis effects were present, at least no measurable difference in limiting values

†† Consisting of drilled passages, bores and the volume of the bourdon tube.

[†] It is to be noted that in Figure 45 the ordinate is the mean recess depth, that is the recess volume divided by the recess area.

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of stability parameters was noted. It sults of observations of this rather remarkable phenomenon are shown in Figure 40. It is realized, of course, that the region "unstable if disturbed" is quite areamany, since, ideally, the system could remain in the state of unstable equilibrium if all disturbances, no matter how small, were absent.

la the conduct of stability experiments described up to this point, the emphasis was rather on qualitative than on quantitative aspects of bearing performance. Subsequent tests, although their description and results are presented in this section under the heading of "preliminary", were carried out with considerably greater accuracy and precision of measurements. Closer spacing of intervals at which data was recorded and the determination of frequencies of auto-oscillations on the threshold of instability contributed to the detection and elimination of certain troublesome characteristics, inherent in the test rig, and subsequent improvements in correlation between predicted and experimental results.

Stability boundaries, obtained with a twelve supply nozzle, plane-faced piston, under constant load (472 lb) conditions. for 0.477 x 10^{-2} and 11.68×10^{-2} lb-sec² in effective bearing masses[‡], are presented and compared with predicted results in Figure 47. Measured and predicted critical frequencies, ω_c , associated with limiting values of parameters on the observed threshold of instability and their calculated equivalents, for which the roots of the characteristic equation (34b) on the axis of imaginaries were $8 = \pm i\,\omega_c$, are presented and compared in Figure 48. Results of a test conducted under reduced load (222 lb) conditions are shown in Figure 49. The stability boundaries referred to in the foregoing, although similar in shape to those shown in Figures 44, 45 and 46, exhibited yet another, unusual property in regions denoted by "resonance" on all pertinent figures. This peculiar trend in all loci, characterized by inflection points and abrupt changes in curvature, occurred invariably at frequencies between 220 and 225 cps, indicating the existence of resonance in the system.

The phenomenon described in the foregoing, a major source of discrepancy between theory and experiment, might well have gone unnoticed if critical values of supply pressure and recess depth had been recorded at more widely spaced intervals. Fortunately also, frequencies were recorded in parallel with other measurements, so that the local, abrupt transitions in several stability loci could be identified with the same value of approximately 220-225 cps. The preliminary dynamic tests indicated a considerable area of qualitative and quantitative disagreement between predicted and experimental results, far in excess of what might have been anticipated on the basis of comparison between calculated and actual, static bearing characteristics. There remained the problem of detecting possible sources of trouble inherent in the experimental apparatus and the applicat a of corrective measures before final experiments could be conducted. Specifically, it was essential to (a) identify parts and components of the test rig assembly responsible for the existence of resonance at particular frequencies of auto-oscillation and (b) to investigate possible interactions between the motion of the bearing and finid flow in regulators, supply lines, guide bearings, the loading cylinder, etc.

[†] The effective bearing rescionsisted of the shaft and lower thrust plate assembly (Approximately 25 lb and 45 lb weights respectively).

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3. Concluding Stability Experiments

This section begins with the description of preparatory test and adjustments of the experimental apparatus which preceded and were of considerable importance in the final, experimental phase of the investigation. It contains a detailed report of concluding experiments and ends with an account of tests, performed as a check of repeatability of results.

It was suspected that the singular trends associated with frequencies of auto-oscillations in the neighborhood of 220-225 cps, were caused by resonance of the entire test stand, considered as one large mass (Approximately 750 lb weight), supported on an elastic foundation. The possibility of exciting one of the graver modes of vibrations in the massive, upper thrust plate was highly unlikely, but could not be entirely excluded, because of the rather indefinite manner of support on three columns and levelling screws.

The test bearing assembly was bolted to a very sturdy and rigid tripod (see Figure 18 for example), mounted directly on an asphalt tile covered, concrete floor. Crude deflection measurements, using a dial indicator and the experimenter's weight for the applied load, yielded a natural frequency for the test rig mass and the clastic foundation of approximately 230 cps, a value extremely close to the narrow band in which the inflection points and rapid changes in curvature of stability loci were observed. In order to measure the natural frequency of this mass-spring system, as well as the response of the upper thrust plate, it was decided to utilize the floated shaft as the seismic mass and the primary capacitance probe as the sensing element of a vibrometer, providently, though inadvertently incorporated in the test rig design. A very minute, axial load was applied to the shaft thrust plate and balanced by the pressure in the loading cylinder. This furnished the desired "soft" suspension for the floated mass and a correspondingly low, damped natural frequency of less than 1 cps. The base of the tripod was then pressed down and released, while the response was recorded by means of the oscilloscope camera. As anticipated, the recorded frequency was approximately 220-225 cps.

The cause of the observed singularities thus firmly established, the entire test rig structure was mounted on isolators. A record, obtained in a manner similar to that described in the foregoing, showed that the natural frequency of the isolated structure was 15 cps. A further, effective reduction of isolator stiffness, such as could be obtained with a Julius suspension, for example, or a sizeable increase in mass, was not feasible because of physical limitations. The response of the upper thrust plate was also of interest. The plate was struck a light blow near the center with a small hammer, and the resulting trace of the cathode ray oscilloscope was recorded. The frequency observed in this case was approximately 730 cps, twice as large as the maximum frequency of auto-oscillations encountered in all experiments, but considerably lower than the magnitude estimated in the design phase of the apparatus.

Photographic records of frequency measurements described in the preceding paragraphs are presented in Figure 50, in which I represents the trace obtained with the structure resting on the floor, II is the response of the upper thrust plate and III refers to the structure when mounted on isolators. The uneven appearance of traces is due to the fact that, with relatively low pressures applied at the extremities, the shaft drifted continuously in the axial direction, producing corresponding changes in the electrostatic field between the probe and the "seismic mass". The oscillations of the upper thrust plate. II, are superimposed on the trace produced by vibrations of the test rig structure on isolators, both induced by the light hammer blow.

The concluding stability experiments were conducted with an isolated structure, so that the ratios of lowest, observed frequencies of auto-oscillations and the natural frequency of the assembly-isolator system were in the order of 14:1. Hearing alignment, leakproofness, zero settings of instruments etc., were thoroughly checked. A low frequency generator, the triangular wave output of which was used as a marker on photographic records, was checked against an electronic, digital counter and found to be stable and accurate within 1 percent in the 500-1200 cps band width. Particularly great care was taken in recording readings of the recess depth dial indicator and of pressure gauges. Pressure readings were corrected to the nearest 0.05 psi for head loss between the measuring station and the point of admission to the reservoir, upstream of the supply mozeles. In approaching the critical recess depth on the threshold of instability, the piston was locked, so that final setting was made by very gradually overcoming a substantial amount of frictional resistance, in addition to that offered by four sliding "O"-ring seals. Whenever the stability boundary was approached by varying the supply pressure, the regulator control was adjusted in a manner, for which, perhaps, the most apt description would be "creeping".

It will be recalled that the stability analysis was based on linearized equations of motion, implying among other things that, in the course of the experimental part of this investigation, securibly small amplitudes of oscillation, possibly one percent of the equilibrium gap width, would have to be observed. Now, since sources of small, random disturbances were always present in the fluid, the foundation and the surrounding atmosphere, more or less well defined wave forms of bearing response, with amplitudes of the order of microinches, were always observed on the display of the cathode ray oscilloscope. On the other hand, no significant growth of oscillation was noted for very large changes of supply pressure and recess depth, until their values approached a region in which relatively minute changes in either parameter were accompanied by an abrupt increase in the amplitude of vibration. In this narrow transition region the amplitude of vibration was modulated by irregular "beats". Their incidence, relative to the frequency of oscillation, occurred at more frequent intervals for large values of the critical recess depth.

Perfect discontinuities and ideally defined boundaries seldom occur in physical problems. Nevertheless, the transition in amplitudes from the microinch noise level to magnitudes approaching the gap width itself was invariably accomplished by changes smaller than one percent of the stability parameters designated as "critical". Thus the stability boundary is sharply defined. Otherwise stated, the amplitude of oscillation remained very small and its rate of change (slope) with recess depth, at constant supply pressure!, remained essentially zero, until both changed almost discontinuously in a narrow region, the amplitude becoming very large and its rate of change (slope) almost infinite.

The concepts and ideas contained in the preceding paragraphs can be summarized by stating (a) that amplitudes of the order of 10⁻⁵ inches were small compared with the bearing gap width, (b) that the evailable instruments were capable of detecting and measuring amplitudes of the order of 10⁻⁵ inches and, moreover, (c) that the order of magnitude of 10⁻⁵ inches was not very critical as a criterion of limiting values of recess depth and supply pressure at the inception of instability.

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The foregoing statement may be substantiated by referring to Figures 51, 52, 53 and 54, which illustrate the abrupt transition in amplitude growth when approaching the boundary from the stable side, by increasing (or decreasing) the recess depth at several settings of the supply pressure. The lower photographs in each row were obtained with long exposure times and slow sweep rates. They show quite clearly the irregular "beats" referred to previously. The upper photographs display wave forms of auto-oscillations in random time intervals and were obtained with sweep rates one thousand times faster than corresponding photographs in the lower rows.

Stability boundaries and frequency determinations, obtained in the course of concluding experiments, are presented and compared with predicted results in Figures 55 and 56. A corresponding tabulation of experimental data is included in Appendix 4, following the table of calculated results. Photographic records of frequency measurements are shown in Figures 57 and 58. In the presence of irregular beats, described in the foregoing paragraphs, particularly at large values of the recess depth, the determination of critical parameters was unavoidably subject to judgment of the observer. The procedure followed by the experimenter was to observe the trace on the cathode ray oscilloscope while adjusting the recess depth, without noting the reading of the recess depth dial indicator. The objective was to avoid bias in selecting the point at which auto-oscillations were estimated to have reached amplitudes between approximately 1 x 10^{-5} to 2 x 10^{-5} inches. An alternative method was used for a number of points in which the stability boundary was approached by varying the supply pressure instead of the recess depth, thus providing a check on the reliability of measurement. In the latter case, the attention of the experimenter was focushed on the oscilloscope display without observing the pressure gauge reading until the critical point was determined. No significant differences were noted, regardless of the manner in which the stahility boundary was approached, indicating that results were reproducible according to the selected criterion, as well as rather insensitive to inexactitudes involved in its selection. Several measurements were repeated on days when the barometric pressure and the ambient (room) temperature were slightly higher, or lower, but the observed differences were negligibly small. It is sotimated that the repeatability of limiting stability parameter measurements is at least within 1 to 2percent of readings obtained in the course of concluding experimental runs.

The very substantial and, in this case, rather encouraging qualitative and quantitative differences in results of preliminary and concluding experiments were attributed entirely to the isolation of the test rig structure, since no other changes were effected in the system. On the other hand, all static and dynamic experiments seemed to indicate that, under certain conditions, even minute changes in system characteristics had an enormous effect on the stability of the bearing. In the final phase of this investigation, therefore, the experiments were accompanied by numerous and important secondary tests, with the objective of (a) discovering possible causes of remaining divergencies between theory and experiment, particularly such as might have accounted for the double-valuedness of stability loci, or, failing this, (b) adding weight to the reliability of the concluding experiments. Those secondary tests will now be described.

All experimentally determined stability boundaries were double-valued and exhibited an "upper" branch, not predicted by the present analysis. Although no calculated data were available for recess pressures other than 73.5 psia (corresponding to a 472 lb load), a stability test under reduced load conditions (222 lb), cursor 1 mentioned in a preceding section, was carried out. The reduced load test was dictated by the desirability of ascertaining whether the double-valuedness would also persist in the case of a locus corresponding to lower Reynolds number,

$$N_{\rm R} = \frac{\rho_{\rm co} \Gamma_{\rm ro} H_{\rm o}}{\mu} = \frac{W_{\rm o}}{2\pi \mu R_{\rm r}}$$
. A qualitative comparison of results in Figures 55 and 49, or Figures 55.

ures 47 and 49, in conjunction with reference to Figures 41 and 42, clearly indicates the presence of "upper branches" in loci corresponding to different ranges of the Reynolds number.

Next, effects of misalignment were investigated. This investigation was accomplished by two methods. First, the constraint of the shaft† was removed and the relative positions of the upper and lower thrust plates were alrered. These changes produced a very substantial misalignment due to the run-out of the lower thrust surface with respect to the shaft journals. Although very minor differences in limiting values of supply pressure and recess depth were noted, no significant change in the trend of the stability boundary was observed. Similar conditions prevailed when the rotor was brought up to a speed of approximately 2500 rpm, by means of an air jet directed onto the turbine wheel buckets. In the second misalignment test, the supply pressures of the upper and lower guide bearings was varied in such a manner as to tilt the shaft within the limits of hearing clearance. In addition to misalignment, the accompanying effect, in this case, was to change the "stiffness" of the guide bearings. No substantial changes in stability characteristics were observed, except when the supply pressure to one, or both bearings, was reduced to the extent which precluded their functioning as effective guides and constraints, or when metal to metal contact between the bearings and journals was established.

Experiments conducted with the isolated and non-isolated test rig assembly not only demonstrated local effects in the vicinity of the resonance point, but also the presence of large differences in limiting values of stability parameters for frequencies of incipient auto-oscillation considerably removed from the critical. The existence of other critical frequencies in the experimental band width and the effect of small vibrations of the upper thrust plate could not be entirely dismissed. It was, therefore, decided to stiffen the upper thrust plate. This was accomplished by placing three 3-4 inch diameter jacking screws between the column-bracing, upper plate and the upper thrust plate (see assembly drawing Figure 7) in positions straddling the columns and as close to the bearing center as was feasible. The jacking resulted in a slight amount of controlled, symmetrical deflection. It was known, however, at that time that no significant changes in stability characteristics were associated with a moderate degree of misalignment. The rigidity of the upper thrust plate thus considerably increased, measurements for a series of previously established, experimental points were repeated, without, however, any appreciable departures having been noted.

In the analysis, as well as in the course of experimental investigat. In, it was postulated that the load, and consequently the pressure in the loading cylinder, remained constant at all times. Accordingly, the design of the loading cell was such that fractional pressure changes, associated with motion of the shaft, were to be of the order of smallness of the displaced to total cylinder volume ratio. (Approximately 10⁻⁶.) There existed the possibility, hower, that the lower end of the shaft, acting as a piston type source, gave rise to a complex, stationary wave system. If wave reinforcement occurred, the effect could be appreciable and divergence between the theoretical and the physical models significant. The possible presence and influence of resonance in the chamber could be confirmed or disproved by altering the shape and volume of the

[†] Two jets impinging on each side a guide fin, mounted on the shaft collar. See Figure 18

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loading evlinder. A simple method was employed, in which the cylinder was fitted with a small standpipe and ther filled with water in increments up to three quarters of the total volume. No significant departures, however, from previously established results were observed.

The validity of the concept of a "constant pressure supply reservoir" depends on the absence of pulsations transmitted through the supply restrictors. The likelihood of propagation and, possibly, of reflection of pressure disturbances apstream of the supply nozzles could not be dismissed. Infortunately, instablatic of suitably small and sensitive pressure pick-ups, or hot wire anomometers, in the immediate vicinity of the nozzle entrance and exit would have involved substantial changes in design and elaborate, additional instrumentation. Subsequent investigations, therefore, were limited to a series of simple checks, intended to locate possible sources of trouble in the air supply system. It is, perhaps, both useful and instructive to render a brief account of some of the steps taken in this "trouble-shooting" procedure:

- a. A two cubic foot plenum chamber was installed at a point where the supply line was joined to the upper threst plate (see assembly drawing in Figure 7), in order to increase the capacity of the supply reservoir and provide a zone in which small fluid disturbances could be dissipated.
- b. The compressor was shut off so that no unsteadiness of flow originated at the source of the supply while readings were recorded. The capacity of the main supply reservoir was sufficiently large to maintain a constant supply pressure in a time interval required to perform one or several measurements.
- Since instabilities of pressure regulators and pneumatic valves are similar in nature to hose occurring in externally pressurized bearings, the regulators and valves, placed in series in lines supplying the bearings and leading cylinder (see Figure 17), were adjusted for varying degrees of pressure drop across the metering elements. Various settings were made and a number of measurements were repeated.

None of the foregoing measures had any effect on the stability characteristics of the test bearing.

Valid comparisons between theoretical and experimental results could only be made if the pitching (cocking) motion of the shaft remained small in comparison with the amplitudes of axial oscillation. In the course of several preliminary and final runs, the auxiliary capacitance probe was mounted in different positions around and along the shaft, but no measurable amplitudes were detected. Preliminary calculations carried out in the design phase of the apparatus, in which the shaft and the guide bearings were considered as a simple, two-degree-of-freedom system, indicated that the slower mode of vibration could possibly be excited by frequencies of auto-oscillation in the upper range of the experimental band width. Figure 59 shows results of a vibration test, in which the auxiliary capacitance probe was located in a position where large amplitudes at frequencies close to that of the first mode could most readily be observed. Since the sensitivity of the auxiliary probe was considerably less than that of the primary probe, the gain of the primary instrument was decreased and the amplitude of auto-oscillations increased to 4 x 10⁻⁴ inches, approximately twenty times the value observed on the threshold of instability. This permitted a better comparison to be drawn between amplitudes of axial and pitching motions. The frequency of

f Along the six inch outer diameter of the shaft thrust plate.

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auto-oscillations was then varied from 375 to 200 cps. The second photograph in Figure 59 shows the largest amplitude of pitching which was observed, occurring at 2091 rad/sec (333 cps). It is realized of coarse, that more than two modes could be excited, that the shaft could perform small, conical gyrations within the limits of bearing clearance, or momentarily rotate and translate, but not necessarily in the plane of the capacitance probe. Nevertheless, Figure 59 shows the largest amplitude ratio (approximately 100:1) ever observed in any of the monitoring positions and there is little doubt, therefore, that the overall effect of pitching was a very minor one.

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M. DISCUSSION

1. Comparison of Analytical and Experimental Results

Comparison of theoretical and experimental loci in Figure 55 indicates reasonably good agreement in the region in which pressure differences between the supply reservoir and the recess are highest. In this region, values of 8, obtained from the present analysis represent a considerable improvement when compared with those predicted from the simplified, lumped-parameter theory. (See Figure 5.) As the pressure drop across the supply nozzle decreases, the deviation of empirical curves from their colculated equivalents becomes more pronounced. Beyond the points of vertical tangency neither quantitative nor qualitative agreement exists.

With regard to slope, empirical curves and those predicted from the present analysis agree fairly well over a considerable part of the experimental range. The same situation does not hold true for the single locus obtained from the simplified theory. The present analysis predicts conservative (safe) limits, whereas the simplified analysis gives values which are either too high or too low. A most significant improvement, introduced through the refinements incorporated in the distributed-parameter approach, is that the present analysis gives a correct interpretation with regard to influence of the effective bearing mass on stability, a fact to which experimental results lend unequivocal support. As emphasized previously, one of the major shortcomings of lumped-parameter analyses is that they predict the same locus, regardless of magnitude of the bearing mass.

It is interesting to note that for the larger mass, agreement between predicted and experimental loci in Figure 53 is better and extends over a larger portion of the curves. It is more than probable that, as the bearing mass increases, agreement between predicted and actual results progressively improves. This inference may be particularly important, because in actual applications one might expect considerably higher than 0.05 or 0.10 weight to thrust ratios. Since from a practical point of view one is usually interested in "safe depths" of the order of 5 x 10⁻³ to 20 x 10⁻³ inches, it is encouraging to note that is is precisely in this region where predictions based on the present analysis constitute a considerable improvement in comparison with those based on simplified analyses.

2. Remarks on the Relative Validity of Theoretical Assumptions and Their Applicability To the Experimental Model

The present investigation included both, analysis and experiment. To the investigators, who have engaged in this dual undertaking, falls the difficult task of accounting for disagreement in areas where it exists. In what follows, an attempt is made to inquire into likely causes of divergence between analytical predictions and empirical results, particularly the single and double valuedness of the respective stability loci.

It will be recalled that the dynamic lubrication equation (4) was required to satisfy a boundary condition at the outer bearing perimeter and to be compatible with the continuity equation

[†] The bearing mass becomes a significant stability parameter in presence of appreciable, external damping only. (See Appendix 2.)

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(7) of the variable-volume recess. Now, in implementing the continuity equation, it was assumed that the inflow through the supply rozzle, W₁, and the outflow along the perimeter of the recess, W₂, could be considered as quasi-steady. The quasi-steady approach has been successfully employed in problems of charging and discharging of fixed and variable-volume cylinders, in research related to the dynamics of pneumatic controls. A typical example is the work of Shearer [9]. The flow through orifices, under pulsating downstream conditions, has been investigated, both theoretically, and experimentally, by Schultz-Grupper [46]. He suggested that limits of applicability of steady-flow equations could be assessed from the reciprocal of the Stroubal number:

$$\phi = \frac{\overline{U}t_o}{d}$$

T = Average velocity

t - Period of pulsation

d = Orifice diameter

which is directly related in unidimensional, inviscid flow to the ratio of local and convective acceleration components. $\Gamma \frac{\partial \Gamma}{\partial x} / \frac{\partial \Gamma}{\partial t}$. He concluded, that for values of $\phi > 510$, the steady-

flow equations yielded accurate values of instantaneous flow rates and the effect of local acceleration was negligible. Although maximum values of ϕ obtained in the course of present experiments were larger that 10^{3} , magnitudes of ϕ were generally comparable with 510, and thus not sufficiently far removed from a transition zone, in which the effect of pulsation may have been significant. Other investigators discovered that pulsations propagated upstream of the restrictor and gave rise to complex wave patterns and phase relations on either side of the orifice [47, 48, 19, 59].

The adequacy of considering inflow as quasi-steady is questionable, at least in certain ranges of pressure, frequency and geometrical parameters of the system. In the limiting case, when P_c/P_s approaches the critical ratio, no pressure pulses propagate apstream of the nozzle throat. If one assumes, however, that acoustic equations hold when P_r/P_s approaches unity, the theory of horns, to which the supply nozzles bear a geometrical resemblance, predicts definite phase relations between pressure and flow at the throat [64]. The existence, therefore, of appreciable time lags cannot be entirely dismissed, in which case the assumed, "in phase" perturbation relation, $w_1 = C_3 p_r$, may be deficient.

If we now direct our attention to the outflow from the recess, the entrance effects, associated with fluid acceleration and flow separation at the sharp edge of the perimeter, are further complicated by the variation of the area of admission to the slot under dynamic conditions. Here,

the use of equation (9), e.g., $W_2 = -(\text{constant}) H^3 P_r \frac{\partial P_r}{\partial r}$, implied not only that the outflow could

be considered as quasi-steady, but also that there was no transition and that a viscous, laminar flow regime became at once established as the fluid entered the slot. Consider also the case of small-amplitude vibration when the recess volume is large and the pressure deviation, p_{r_s} to decome very small in comparison with p, the perturbation pressure in the slot. In fact, due to

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the trapping and squeezing of the fluid in the slot, maxima of p are likely to occur close to the texess perimeter, where the gas is relatively dense. This may cause large variations of the perturbation pressure gradient in the immediate vicinity of the recess and, in turn, induce appreciable fluid acceleration and deceleration in the region of admission to the slot. Moreover, the

linearized expression, $w_2 = C_3 h + C_5 p_r + C_6 \frac{\partial p_r}{\partial r}$, corresponding to equation (9), does not take

into account the complex phenomena occurring in the neighborhood of the recess boundary. Divergence of results may be due partly to the cumulative discrepancy involved in expressing the difference, $\mathbf{w}_1 = \mathbf{w}_2$, corresponding to the righthand side of the continuity equation (7).

Next, we consider possible shortcomings of assumptions involved in the mass accumulation term on the left-hand side of the continuity equation (7). If we now focus our attention on the internal processes occurring within the variable-volume recess, such as the impingement, deflection or disintegration of jets and the interaction between decelerating and accelerating fluid streams, the physical picture defies mathematical description. Unavoidably, therefore, it becomes necessary to resort to simplifying assumptions, or postulates, such as uniformity of "average" properties at any instant of time. The latter assumption was made in the qualitative analysis of periodic charging and discharging of the variable-volume recess in Appendix 5.

Granted the high degree of oversimplification in formulating the problem, the analysis of Appendix 5 nevertheless suggests that the pressure and density in the recess are not in phase. Numerical examples, indicate, however, that no appreciable time lag is involved, so that the process may be reasonably well described by $P^-\rho^n$ = constant. Although the exponent, n, is then not a function of time, it does depend on a dimensionless "charge" parameter, $Q = W_0/\rho_{r0}V_{r0}\omega$, in which W_0 , ρ_{r0} , V_{r0} refer to the equilibrium flow rate, the recess gas density and the recess volume, and ω is the circular frequency of oscillation.

Considerable numerical discrepancies between theoretical and experimental results could be accounted for by selecting more "representative" values of the exponent n, but it is by no means implied here that an explanation for the double valuedness of experimental loci could be supplied by assigning to n values other than y = 1, in the recess, or other than y = 1 in the slot.^{††}

It is considered that the inertia forces in the slot were small in comparison with viscous forces. Although no definite, analytical proof has been furnished to support this contention, the derivation in Appendix 6 suggests that the neglect of inertia contributions in the bearing clearance may not be very serious, and that the dynamic lubrication equation (4) is a good first approximation. Moreover, in the presence of significant inertia effects, one would expect the disagreement between predicted and empirical results to be greatest at relatively high frequencies of oscillation, whereas exactly the opposite is indicated by the experimental evidence.

In the foregoing discussion, an attempt was made to probe into the more questionable aspects of the present analysis. A critical inquiry would be incomplete and one-sided, if one omitted to

[†] An analogous condition is illustrated diagrammatically in Figure 6a., showing a greenly exaggerated, instantaneous pressure profile and positive gradient at the edge of the recess.

^{††} In the slot, $P/\rho = constant$ was the assumed relation. See also Appendix 6.

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examine both the experimental model and the procedure for possible deficiencies and inherent sources of error. Here, however, the numerous, secondary tests, described in the section "Concluding Stability Experiments." have narrowed down considerably the area of search for a feasible explanation.

The turning point in the experimental phase of this investigation was the discovery of resonance in the system. Isolation of the test structure not only altered the shape of stability loci near resonance points, but also displaced the curves in a direction effecting considerably better agreement between theory and experiment. The extent to which actual motion departs from the idealization of an undamped, single-degree-of-freedom system, for which perfect isolation, absolute rigidity and absence of external damping are assumed, is most difficult to assess. One need only to consider that 10⁻⁶ inches represented 10 percent of what could be meaningfully interpreted in the presence of mechanical and electronic noise. Since the capacitance gauge measured the relative, instantaneous displacement of bearing surfaces at a point, it provided no information with regard to the absolute motion of boundaries. Nor was it feasible to furnish a perfectly isolated and immobile reference frame for external mounting of capacitance probes.

The extension of the simplified analysis of Appendix 2 to a damped, two-degrees-of-freedom system suggested the possibility of a double valued stability locus. An approximate value of the critical damping ratio was estimated from Figure 50.† Calculations then indicated limiting values of critical recess depth on the upper branch of the locus to be of the order 103 inches, as compared with 10-1 inches in the case of experimental results. The simplified analysis, of course, lends only qualitative support to the existence of double valued loci and may predict grossly exaggerated results in this region. It is not unlikely that the extension of the present analysis. to include the effects of elastic and damping properties of the entire system, would result in more realistic predictions of critical values of stability parameters. At any rate, one cannot rule out that the divergence between theory and experiment was due to appreciable motion and accompanying dissipative effects in the supporting structure, whereas perfect rigidity and motion of one boundary only were hypothesized for the idealized model. The importance of considering the motion of the supporting structure was stressed in a recent paper by Tsai [52], who investigated the stability of a simple, pneumatic pressure reducer. The author states in the introduction: "Also, the vibrations of the mounting structure may induce undesirable oscillations in the reducer. To obtain a complete picture of performance, one must therefore investigate the dynamic characteristics of the reducer and analyze the problems of its natural frequency and stability."

() f equal importance is the extent to which the actual, steady-flow pattern conforms to that which has been postulated for the idealized model. The flow of compressible fluids in narrow channels and in externally-pressurized bearings, in various Reynolds and Mach number regimes, has been the subject of numerous, theoretical and experimental investigations. †† The Reynolds and Mach numbers corresponding to the flow range of the present investigation were sensibly small, and deviations from calculated, steady-flow bearing characteristics were of the order 2-5 percent.

Nevertheless, once oscillation is started, the influence of entrance phenomena on stability may become of far greater significance than their effect under static conditions would seem to indicate.

[†] Trace of decaying vibration of structure when mo nted on isolators.

TT Representative examples may be found in references [19, 20, 21, 22, 23, 24, 27, 31]. A rather complete list is contained in a bibliography by F.B. Sciulli, reference [44].

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The flow pattern in the entrance region does not conform to the idealization of the experimental model. In the flow around the sharp edge of the recess, separation takes place and the floid stream converges, a toroidal vortex forming beneath the contraction. McGinn f351 obtained streamline patterns for water flow in a sharp-edged, radial diffuser by means of dye filaments, and recorded photographically the vortices formed downstream of the separation point. Shires [22], using air, demonstrated the existence of pressure depressions in the entrance zones of several, parallel-surface slot configurations, for various pressure ratios and slot width. The Reynolds number in the experiments of McGinn and Shires was of the same order as that in the present investigation.

Consider a vibration, induced by a random disturbance and accompanied by changes of pressure gradient in the entrance region. The vibration will cause alternate elongation and contraction of the transverse dimension of the vortex ring. The outflow from the recess depends on the width of the effective flow area, rather than on the width of the slot. The amplitude and phase relation between the slot width and the width of the contraction may not be a simple one, and the representation of the instantaneous flow rate by the expression $\mathbb{N}_2 = -(\text{constant}) \, \mathbb{H}^3 \mathrm{P}_r \, \frac{\partial \mathrm{P}_r}{\partial r}$ may lead to considerable error. Conceivably also, an appreciable amount of energy, which would otherwise be dissipated in the process of a self-sustained oscillation, may instead be absorbed through entrance losses. The entrance zone may thus provide an internal damping mechanism and have a stabilizing effect on the hearing. Since entrance phenomena were not considered in the analysis, theory may predict instability in regions which experiments show to be stable.

On the other hand, as one follows the lower branch of a locus and departure from predicted results increases, the Reynolds and Mach numbers decrease, so that entrance effects become less pronounced, up to the point of vertical tangency of the locus. Thereafter, the opposite holds true. It would be inconsistent, therefore, to attribute the main cause of divergence of results solely to entrance effects, except to say that their disregard may have been a contributing factor.

In this section, a number of likely, but by no means proven sources of divergence between theoretical and empirical results, have been discussed. Although the observed discrepancies may have been a cumulative result of several deficiencies involved in the theoretical assumptions, as well as those inherent in the experimental apparatus, the most probable sources of error which suggest themselves are:

- a The possible in sufficiency of the quasi-steady flow representation and of the postulation of uniform properties in expressing the continuity equation of the variable-volume re-
- b. An appreciable effect of the relative motion of the bearing surfaces, associated with imperfect isolation and or the distributed, clastic and damping properties of the supporting structure.
- c. The presence of entrance effects in the experimental model, contrasted v = | ieir neglect in the present analysis.

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VII. CONCLUDING REMARKS AND RECOMMENDATIONS

It has been demonstrated that the dynamic lubrication equation (4) gives a more faithful representation of the effects of partial trapping and squeezing of a compressible fluid film in a long and narrow slot than could hitherto be obtained with the aid of arbitrary assumptions with regard to the flow and the pressure profile. Moreover, the present results have been obtained without resort to any correction factors. It has also been shown, both theoretically and experimentally, that the bearing mass has a significant effect on stability and that stability is enhanced by decreasing the bearing mass. As a consequence of results of the analytical and the experimental phases of this investigation, it has been possible to assess more critically the earlier, lumped-parameter theories.

Experience gained in the course of experiments has shown that the response of the bearing can be greatly influenced by the method of mounting, indicating that in actual applications the mass and the elastic and damping properties of the supporting structure may have to be considered in formulating the stability problem. Stability has been shown to be extremely sensitive to minute changes of certain bearing parameters and system characteristics and quite insensitive to others. The experimental results have also substantiated the validity of the linearized approach in the analysis, since, in regions designated as "stable," no self-sustaining oscillation could be induced, regardless of the magnitude of disturbance.

There are several areas in which the present research could be further extended and supplemented. The stability of bearings cannot be treated as a separate problem and must be dealt with in conjunction with other aspects of an entire system. It is not always possible, however, to formulate the equations of motion of a complex system in terms of distributed parameters. Even after such formulation, it may be impossible to obtain solutions. Moreover, system considerations aside, the distributed parameter approach may also become too involved for more complex bearing configurations. Clearly, therefore, a more rational method of lumped-parameter representation would be desirable.

The present analysis suggests an approach in this direction which merits further consideration. It will be recalled in the case of the rectangular geometry, that in the series representation of the functions y_I and y_{II} we capitalized on the smallness of the parameter ϵ and neglected higher order terms of the expansion. When the first four terms of the expansion are retained, the characteristic equation reduces to a polynomial of the third degree in s. On the other hand, it has been shown in Appendix 2 that the characteristic equation obtained from the simple analysis is also a polynomial of the third degree in s. Since both equations are of the same form and differ only in their coefficients, the results of the present analysis may be helpful in devising a rational method of correlation of the distributed and the lumped-parameter representations. In the case of the circular bearing, it may also be feasible to obtain solutions y and y in the form of series expansions in terms of the small parameter, $12\mu R_r^2/P_{ro} H_o^2$, which characterizes the equation (19b). It may then be possible to represent the characteristic equation (31b) by a polynomial in s, following a procedure analogous to that which was employed in the case of the rectangular bearing configuration. A correlation of coefficients in the characteristic polynomials of the present and simplified analyses would give the advantage of formulating the problem in terms of ordinary, rather than partial differential equations.

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It would be desirable to retain the quasi-steady flow representation in future stability analyses, because of the inherent simplicity of such an approach. Nevertheless, in certain flow regimes, it may become necessary to modify the mathematical description of the charging – discharging process of variable volumes in bearings. Perhaps, as a first step in this direction, it would be useful to determine the throat impedataces of simple nozzles and of orifices, in a manner analogous to derivations in the acoustic theory. A better understanding of the phenomena occurring in the entrance region of a siot is also needed, before an attempt is made at an improved mathematical description of fluid flow in the entrance zone. A study of streamline patterns and of vortex formations should be made, when the boundary oscillates in the transverse direction of the slot. A complete time record of flow patterns could be obtained with the aid of a high speed camera, using otherwise methods similar to those employed by McGinn [35] for the case of steady flow of water in the entrance zone of a sharp-edged, radial slot.

Advance consideration has been given to future experiments which would involve rotation of the shaft. For this purpose, an air-driven turbine has been incorporated in the design of the shaft, details of which are shown in Figure 13. The effect on stability and other rotor characteristics due to pressure gradients, induced through centrifugal forces and surface misalignment, is of considerable interest and should be studied. Also, additional stability loci could be obtained for various pressure ratios and types of supply restrictor, under rotating, or non-rotating conditions. The experimental apparatus is capable of providing a great deal of valuable information and can also be modified for the purpose of experimentation with other bearing configurations. It is recommended, therefore, that full use be made in the future of the existing facility.

Finally, since the simple geometries considered in this investigation are frequently encountered in practical applications, and since good agreement exists in regions which are of interest, the programming of a digital computer, to provide design data for a representative range of parameters, is warranted and recommended.

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IX. NOMENCLATURE

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SYMBOL	MEANING	FIRST APPEARANCE	UNITS
Λ_{α}	"Equivalent" area, defined in Appendix 2	A2-1	in ²
A,	Recess area	A2-1, A5-6	in ²
Λ_c^{r}	Coefficient, $= (P_{ro}^2 - P_{at}^2)/X - X_r$	16.	lb^2/in^5
$\overline{A}(s)$	Complex function, defined in text	30 .	4
Bo	Coefficient, $-(P_{ro}^2 - P_{at}^2)/\log_e \frac{R}{R_r}$	16b	lb^2/in^4
C ₁₆	Coefficients, defined in text	15b	
c	Damping constant associated with mass M, Appendix 2	A2-10	lb-sec/in
,c _p	Specific heat at constant pressure	A6-4	in ² /sec ² _oF
e _v	Specific heat at constant volume		in ² /sec ² -°F
$\mathbf{d_{N}}$	Nozzle throat diameter	8	in .
e	Base of natural logarithms, 2.718	16b ·	No dim.
F(t)	Forcing function	6 -	IЬ
. f(t)	Perturbation forcing function in text, (H(t)/H* in Appendix 6)	14, (A6-7)	Ib, (No dim.)
g _{1,2}	Functions of a and Ps, defined in text	43b	iņ
H	Bearing gap width	1	in
H	Bearing gap width, equilibrium	12	ttt
ክ	Bearing gap width perturbation, H - Ho	12	in
h _o	Bearing gap width perturbation amplitude	A56	in
	Pressure integral, defined in text and expressed in Appendix I	26b, A1-3	. 1b
i	√ - 1	33a	No dim.
J	Bessel function	33a	No dim.
K	Spring constant associated with mass M, Appendix 2	A2-10	lb/in
K ₁₆	Coefficients, defined in text	15a	•
k .	Thermal conductivity	46_4	IL/

SYMBOL.	WEANING	FIRST APPEARANCE	UNITS
1.	Bearing load in text and in Appendix 1 (R = R _r in Appendix 6)	A1-9, (A6-7)	lb, (in)
VI	Mass of bearing support	A2-10	lb-ees ² /in
M	lotal gas mass-content of bearing	A2-4	lb-sec ² /in
M _r	Gas mass content of recess volume	7	lb-sec ² /in
m	Rearing mass (Movable, or effective bearing mass)	6	lh-sec ² /in
41	Pressure in bearing gap, abs.	1	lb/in ²
P_{at} .	Atmospheric (ambient) pressure, abr.	. 5	lb/in^2
P	Pressure in bearing gap, abs., equilibrium	6	lb/ia ²
Pr	Pressure in bearing recess, abs.	6 .	lb/in ²
Pro	Pressure in bearing recess, abs., equilibrium	6	lb/in ²
$\mathbf{p}_{\mathbf{g}}$	Supply pressure, abs.	8	lb/in ²
P	Perturbation pressure in bearing gap [†] , P = P _o	12	lb/in^2
Pr	Perturbation pressure in bearing recess, Pr - Pro	12	lb/in²
Q	Complex function, defined in test	28	No dim.
Ģ	"Charge" parameter, defined in Appendix 5	A5-11	No dim.
R	Radius of bearing	5Ъ	in
R _r	Radius of recess	6Ъ	in
4	Gas constant, c _p - c _v	8	in 2/sec 2_°F
г	Radial coordinate	16	in
s	Complex variable	19	1/sec
T	Temperature, abs.	A64	• •F
To	Temperature in bearing gap, abs., equilibrium $(T_o = T_{at} - T_{ro} = T_s)$	8	of.
t ·	Time	3	sec
\overline{v}_i	Velocity functions, defined in Appendix 6	A6-15	No dim.
d	Component of velocity in the x and/or i-direction	A6-1	in/sec
ū	Mean velocity in the x and/or r-direction	1 :	in/sec .

[†] Except in Appendix 5, in which $p = P_p - P_{to}$ is the perturbation pressure in the recess and the subscript "r" is omitted.

SYMBOL	WEANING	FIRST APPEARANCE	UNITS
\bar{v}	Velocity functions, defined in Appendix 6	46-15	No dim.
V _F	Recess volume	A56	in ³
\ \ \ \ \ \ re \ \ \ \ \ \ \ \ \ \ \ \ \	Recess volume, equilibrium	A5-6	in 3
31	Pressure variable, defined in text	18	
%	Bearing gas mass flow rate, equilibrium	16	lb-sec/in
ш,	Rate of gas inflow through supply nozzle	· .	lb-sec.'in
и _с	Rate of gas outflow from recess for outflow from bearing)	7, A5-1, (A2-4)	lb-sec/in
$\overline{\alpha}$	Velocity functions, defined in Appendix 6	. A6-15	No. dim.
w	Velocity component in the z-direction	A6-1	in 'sec
· w ₁	Perturbation inflow, W ₁ - W ₀	A5-6	lb-sec/in
w.,	Perturbation ourflow, $\pi_2 - \pi_0$	A5-6	ib-sec/in
X	Half width of rectangular bearing	5a	in
۸,	Half width of rectangular recess	ба	in
`	Coordinate	la	in
v _{1,11}	Solutions of homogeneous part of equation 19	28, 32a, 37b	
2.	Substitution variable, $z = P_0^{-2}$	18	lb ² 'in ⁴
z	Coordinate	A6-1	in
а	Compressibility parameter, 12μω R _r ² /P _{ro} H _o ²	37b	No dim.
β	Parameter, $1 - \left(\frac{P_{at}}{P_{ro}}\right)^2 / \log_e \frac{R}{Rr}$	37b, A1-3	No dim.
β	Parameter, $H_o/\delta + H_o$	A5-6	No dim.
y	Ratio of specific heats. cp/cv	8	No dim.
δ	Recess depth	10	in
δ_{c}	Critical recess depth	44b	ia
£	Coefficient, $\frac{12u}{H_o^2} \left(\frac{X - X}{P_o^2 - P_{at}^2} \right)^2$, text	20a	in ⁶ -sec/lb ³
E	Dimensionless amplitude, h _o /H _o , Appendix 5	A56	No dim.

SYMBOL.	MEANING	FIRST APPEARANCE	UNITS
<u> 2</u>	Parameter, H*/R = R _r , Appendix 6	A6-7	No dim.
ζ	Dummy variable, corresponding to $z = P_0^{-2}$	28a	lb^2/in^4
η	Coefficient, 12p/H _o ²	20h	lb-sec/in4
\overline{o}_i	Temperature functions, defined in Appendix 6	A6-15	No dim.
λ ₁₅	Coefficients, defined in Appendix 2	A2-4	
Λ_{o5}	Coefficients, defined in Appendix 2	A2-17	
μ	Dynamic viscosity	1	lb-sec/in ²
ν	Kinematic viscosity	A6-7	in ² /sec
ξ	Dimensionless radius, r/R,	37h	No dim.
π	Constant, 3.141	8	No dim.
r_i	Pressure functions, defined in Appendix 6	A6-15	No dim.
ρ	Dummy variable, corresponding to r	28b	i'n
ρ	Gas density in bearing gap	2	$lb-sec^2/in^4$
ρ_{r}	Gas density in bearing recess	10	lb-sec ² /in ⁴
ρ_{ro}	Gas density in bearing recess, equilibrium	11	$lb-sec^2/in^4$
σ	Perturbation density, $\rho_{\rm r} - \rho_{\rm ro}$	A56	$lb-sec^2/in^4$
وا''اا	Real component of y _{1.11}	38Ь	
$\psi_{1,11}$	Imaginary component of y 11	38Ъ	, ,
φ	Phase angle, defined in Appendix 5	A5-36	No dim.
ψ	Phase angle, defined in Appendix 5	A5-37	No dim.
w	Circular frequency of forced vibration	A56	1/sec
4)	In aginary part of s, $\omega = \alpha P_{ro} H_o^2 / 12 \mu R_r^2$	37Ь	1/sec
$\omega_{ m c}$	Citical frequency, corresponding to $s = \pm i\omega_c$ and $\delta = \delta$	37Ь	l/sec

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SUBSCRIPTS AND OPERATORS

SYMBOL.	REFERS TO	FTRST APPEARANCE
at	Atmospheric, or ambient	5
e	Critical	44h
e	Equivalent	A2-1
i	Ordering subscript (also isentropic, Appendix 5)	16, (A5-20)
m	Amplitude of perturbation, Appendix 5	A5-36
r	Recess and recess boundary	6
s	Supply	· 8
o .	Equilibrium condition	6
D	Differentiation with respect to $\overline{t} = \omega t$, Appendix 5	A5-12
(·)	Differentiation with respect to $\overline{t} = \frac{v^*}{L^2}$ t, Appendix 6	A6-8
(+)	Differentiation with respect to t. Appendix 2	A2-1
(')	Differentiation with respect to $z = P_0^2$, text	19a, 32a
(*)	Differentiation with respect to x and r (or $\xi = r/R_p$), text	13, (37b)
(_)	Laplace transform of variable	19
(-)	Dimensionless quantity	A5-6, A6-7
(-)	Mean value of quantity	1
(*)	Reference quantity	Á6—7

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APPENDIX 1 THE PRESSURE INTEGRAL, 8.7

In the integral

$$r = \int_{R_r}^{R} P_o(r) r dr \qquad (A1-1)$$

ir which

$$P_{o}(\mathbf{r}) = P_{ro} \left(1 - \beta \log_{e} \frac{\mathbf{r}}{R_{r}} \right)^{r}$$
(A1-2)

and

$$\mathcal{E} = \frac{1 - \left(\frac{P_{at}}{P_{ro}}\right)^2}{\log \frac{R}{R}}$$
(A1-3)

let

$$2P_o^2 = P_{ro}^2 \, \hat{\epsilon} \, \theta^2 \tag{A1-4}$$

The quantities under the integral sign then become:

$$P_{o} = P_{ro} \left(\frac{\mathcal{E}}{2}\right)^{\frac{1}{2}} \theta$$

$$r = R_{r} \left(\frac{R}{R_{r}}\right)^{\frac{P_{ro}^{2}}{P_{ro}^{2} - P_{nt}^{2}}} e^{-\frac{\theta^{2}}{2}}$$

$$d_{r} = R_{r} \left(\frac{R}{R_{r}}\right)^{\frac{P_{ro}^{2}}{P_{ro}^{2} - P_{nt}^{2}}} e^{-\frac{\theta^{2}}{2}} \tilde{\sigma} d\theta$$

$$(A1-5)$$

The method employed here in deriving an expression for A is identical with that contained in reference [27]

so that:

$$\mathcal{A} = -P_{ro}P_{r}^{2} \left(\frac{R}{R_{r}}\right)^{\frac{2P_{ro}^{2}}{P_{ro}^{2} - P_{at}^{2}}} \left(\frac{\beta}{2}\right)^{\frac{1}{2}} \int_{\theta(R_{r})}^{\theta(R)} \theta^{2} e^{-\theta^{2}} d\theta$$
 (A1-6)

Integration by parts and introduction of the factor $\frac{2}{\sqrt{\pi}}$ then yields:

$$\hat{a} = P_{ro} R_r^2 \left(\frac{\pi \rho}{32}\right)^{\frac{1}{4}} \left(\frac{R}{R_r}\right)^{\frac{2 P_{ro}^2}{P_{ro}^2 - P_{nt}^2}} \left[\frac{2}{\sqrt{\pi}} \theta e^{-\theta^2} - \frac{2}{\sqrt{\pi}} \int e^{-\theta^2} d\theta\right]_{\theta(R_r)}^{\theta(R)} (A1-7)$$

in which

$$\mathcal{E}(R_r) = \left(\frac{2}{\mathcal{E}}\right)^{\frac{1}{2}}$$

$$\mathcal{E}(R) = \frac{P_{at}}{P_{ro}} \left(\frac{2}{\mathcal{E}}\right)^{\frac{1}{2}}$$
(A1-8)

Values of the probability integral

$$\frac{2}{\sqrt{\pi}} \int_0^\theta e^{-x^2} dx$$

are listed in standard mathematical tables. The integral can be used in determining the load capacity, I., of the bearing:

$$I = \pi R_r^2 P_{ro} \left(\frac{2 \lambda}{P_{ro}^2 P_r^2} - \frac{P_{at}}{P_{ro}} \frac{R^2}{R_r^2} + 1 \right)$$
 (A1-9)

A good approximation of the load capacity, L, may also be obtained in assuming a linear pressure profile. (See Figure $\Lambda 1-1$.)

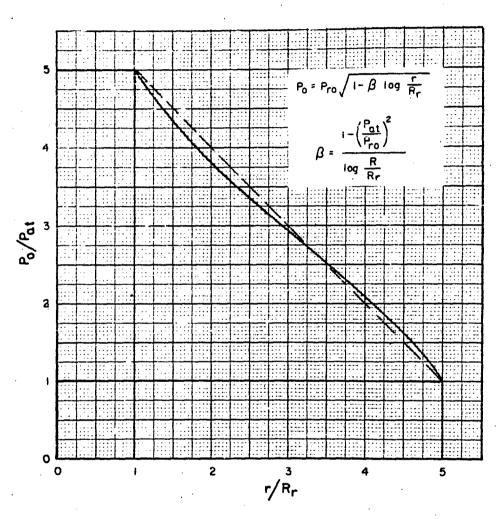


FIG. AI-I. PHESSURE PROFILE AND COMPARISON WITH STRAIGHT LINE APPROXIMATION

APPENDIX 2 SIMPLIFIED STABILITY ANALYSES

In the simplified approach to the stability problem [2,5], the flow in the slot is treated in terms of lumped parameters, and the dynamic pressure profile at any instant of time is assumed to be similar to that which would result if the bearing load were applied statically. In the case of the circular bearing, a further simplification is made by assuming a linear profile along the annulus. (See Figure A1-1, Appendix 1.)

The perturbation equations, which correspond to equations (13), (14) and (15) of the more exact analysis, can then be expressed in terms of the variation of gap width, h. and of the recess pressure. p., as follows.

$$\vec{m} = A_r p_r + \int \int P dA + f(t) = A_e p_r + f(t)$$
 (A2-1)

$$\lambda_1 \dot{\mathbf{h}} + \lambda_2 \dot{\mathbf{p}}_r = -\lambda_4 \mathbf{h} - (\lambda_3 + \lambda_5) \mathbf{p}_r \tag{A2-2}$$

in which

A, = area over recess

A = area over annulus

A = "equivalent" area

the explicit expression for A being:

$$A_{e} = 2Y_{r} \left[1 + \frac{2}{3} \left(\frac{X}{X_{r}} - 1 \right) \frac{\left(\frac{P_{ro}}{P_{at}} \right)^{2} + 2\left(\frac{P_{at}}{P_{ro}} \right) - 3}{\left(\frac{P_{ro}}{P_{at}} - \frac{P_{at}}{P_{ro}} \right)^{2}} \right]$$
(A2-3a)

$$A_e = \frac{1}{3} \pi R_r^2 \left[\left(\frac{R}{R_r} \right)^2 + \left(\frac{R}{R_r} \right) + 1 \right]$$
 (A2-3b)

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while the coefficients λ_i are as follows:

$$\lambda_1 = \left(\frac{\partial M}{\partial H}\right)_o = \frac{2X_r F_{ro}}{\Omega T_o} \left\{ 1 + \frac{2}{3} \left(\frac{X}{X_r} - 1\right) \left(\frac{P_{ro}}{P_{at}}\right) \frac{1 - \left(\frac{P_{at}}{P_{ro}}\right)^3}{\left(\frac{P_{ro}}{P_{at}} - \frac{P_{at}}{P_{ro}}\right)} \right\}$$

$$\lambda_{2} = \left(\frac{\partial M}{\partial P_{r}}\right)_{o} = \frac{2X_{r}H_{o}}{\gamma RT_{o}} \left\{ \left(\frac{\delta}{H_{o}} + 1\right) + \frac{2}{3}\gamma\left(\frac{X}{X_{r}} - 1\right) \frac{\left(\frac{P_{ro}}{P_{at}}\right)^{2} + 2\left(\frac{P_{at}}{P_{ro}}\right) - 3}{\left(\frac{P_{ro}}{P_{at}} - \frac{P_{at}}{P_{ro}}\right)^{2}} \right\}$$

$$\lambda_3 = -\left(\frac{\partial W_1}{\partial P_t}\right)_o = \frac{W_o}{2P_{ro}} \left(\frac{2 - \frac{P_s}{P_{ro}}}{\frac{P_s}{P_{ro}} - 1}\right)$$

$$\lambda_4 = \left(\frac{9M^2}{9H}\right)^2 = \frac{3M^2}{H^2}$$

$$\lambda_5 = \left(\frac{\partial W_2}{\partial P_r}\right)_o = \frac{2\Gamma_{ro}W_o}{P_{ro}^2 - P_{at}^2}$$

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(A2-4b)

$$S_{1} = \left(\frac{2M}{2H}\right)_{0} = \frac{nR_{r}^{2}P_{ro}}{ET_{o}} \left(1 + \left(\frac{P_{ot}}{P_{ro}}\right)\left[\left(\frac{R}{E_{r}}\right)^{2} - 1\right] + \left(1 - \frac{P_{ot}}{P_{ro}}\right)\left(\frac{R}{R_{r}}\right)^{3} - 3\left(\frac{R}{R_{r}}\right) + 2\right)$$

$$I_{2} = \left(\frac{2M}{2P_{r}}\right)_{o} = \frac{\pi R_{r}^{2} H_{o}}{2\pi T_{o}} \left(\frac{\delta}{H_{o}} + 1\right) + \gamma \left(\frac{\left(\frac{R}{R_{r}}\right)^{2} - 3\left(\frac{R}{R_{r}}\right) + 2}{3\left(\frac{R}{R_{r}} - 1\right)}\right)$$

$$\lambda_3 = -\left(\frac{\partial w_1}{\partial P_r}\right)_0 = \frac{w_0}{2P_{ro}} \left(\frac{2 - \frac{P_s}{P_{ro}}}{\frac{P_s}{P_{ro}} - 1}\right)$$

$$y_4 = \left(\frac{2\pi_2}{2H}\right)_0 = \frac{3\pi_0}{H_0}$$

$$v^2 = \left(\frac{3M^3}{5b^2}\right)^2 = \frac{b^2}{b^2} + \frac{5b^2}{b^2}$$

Combining equations (A2-1) and (A2-2) we obtain:

The characteristic equation is a cubic-

$$s^3 + \Lambda_2 s^2 + \Lambda_1 s + \Lambda_0 = 0$$
 (A2-6)

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and stability conditions require that all coefficients A; he positive, and that

$$\Lambda_1 \Lambda_2 > \Lambda_0. \tag{A2-7}$$

The inequality (A2-7) reduces to:

$$\frac{\lambda_1}{\lambda_2} > \frac{\lambda_4}{\lambda_3 + \lambda_5} \tag{A2-8}$$

from which the critical recess depth, indicated with broken lines in Figures 3 and 5, was calculated.

It is to be noted that the coefficients λ_i are analogous to the coefficients C_i and K_i in the more exact analysis, but that there is no one-to-one correspondence, except for λ_3 and λ_4 .

Next, consider the relative, axial motion of two thrust plates, one integral with a rotor, of of mass m, the other with a support, of mass M, resting on isolators, or on an elastic foundation. We associate with the supporting structure the lumped elastic and damping constants, K and c. For the resulting, two-degrees-of-freedom system, shown diagrammatically in the appended Figure A2-1, the following set of equations may be written:

$$m \ddot{x}_2 - A_e p_e = f(t)$$
 (A2-9)

$$\text{M}\ddot{x}_1 + c\dot{x}_1 + Kx_1 + A_e p_r = 0$$
 (A2-10)

$$\lambda_1 h + \lambda_2 p_r + \lambda_4 h + (\lambda_3 + \lambda_5) p_r = 0$$
 (A2-11)

in which

$$h = x_2 - x_1 \tag{A2-12}$$

Applying the Laplace transformation to equations (A2-9) through (A2-11), and assuming initial rest conditions, we obtain:

$$c^2 \overline{\tau}_2 = \frac{A_e}{m} \overline{F}_r = \frac{\overline{f}(s)}{m} \tag{A2-13}$$

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$$\left(s^2 + s \frac{c}{M} + \frac{K}{M}\right) \overline{x}_1 + \frac{A_e}{m} \overline{p}_r = 0 \tag{42-14}$$

$$\bar{x}_2 - \bar{x}_1 = \left(\frac{s_{2} + \lambda_3 + \lambda_5}{s_{1} + \lambda_4}\right) \bar{p}_r = 0$$
 (A2-15)

The characteristic determinant, corresponding to the set of equations (42-13) through (42-15) is:

0	s ²	-h .		
$(-s^2 + Cs + \hat{\epsilon}^2)^2$	n	н	-0	(A2-16)
-1	1	$\frac{s\lambda_2 + \lambda_3 + \lambda_5}{s\lambda_1 + \lambda_4}$		

in which

The characteristic equation is a quintic:

$$\Lambda_5 s^5 + \Lambda_4 s^4 + \Lambda_3 s^3 + \Lambda_2 s^2 + \Lambda_1 s + \Lambda_{\sigma} = 0$$
 (A2-17)

in which the coefficients, Λ_i , are as follows:

$$\Lambda_{5} = \lambda_{2}$$

$$\Lambda_{4} = C\lambda_{2} + (\lambda_{3} + \lambda_{5})$$

$$\Lambda_{3} = \Omega^{2}\lambda_{2} + C(\lambda_{3} + \lambda_{5}) + (B + b)\lambda_{1}$$

$$\Lambda_{2} = \Omega^{2}(\lambda_{3} + \lambda_{5}) + Cb\lambda_{1} + (B + b)\lambda_{4}$$

$$\Lambda_{1} = b(\Omega^{2}\lambda_{1} + C\lambda_{4})$$

$$\Lambda_{0} = b\Omega^{2}\lambda_{4}$$

$$(A2-18)$$

Without loss of generality, one may assume that $\Lambda_3 > 0$. The necessary and sufficient conditions that all roots of the quintic have negative real parts and the system be stable can be stated as follows [59]:

$$\Lambda_4 > 0 \tag{A2-19}$$

$$\frac{1}{2} = \left| \frac{1_4 \Lambda_5}{\Lambda_2 \Lambda_3} \right| = (\Lambda_4 \Lambda_3 - \Lambda_5 \Lambda_2) > 0$$
 (A2-20)

$$Y_{3} = \begin{bmatrix} X_{4} X_{5} & 0 \\ X_{2} X_{3} & X_{4} \\ X_{0} X_{1} & X_{2} \end{bmatrix} = X_{4} (X_{5} X_{0} - X_{4} X_{1}) + X_{2} \Delta_{2} > 0$$
 (A2-21)

$$A_{4} = \begin{bmatrix} A_{4} & A_{5} & 0 & 0 \\ A_{2} & A_{3} & A_{4} & A_{5} \\ A_{0} & A_{1} & A_{2} & A_{3} \\ 0 & 0 & A_{0} & A_{1} \end{bmatrix} = -\left[(A_{5} A_{0} - A_{4} A_{1})^{2} + (A_{3} A_{0} - A_{2} A_{1}) \Delta_{2} \right] > 0$$
(A2-22)

$$\Delta_5 = \Lambda_0 \Lambda_4 > 0 \tag{A2-23}$$

Since Λ_5, Λ_4 and Λ_6 are generally positive, it is sufficient to examine the signs of Δ_2 , Δ_3 and Δ_4 .

Two points in the latter part of this analysis arc of particular interest:

- a. If the damping coefficient, c. is zero, the stability conditions of this system are identical with those given in the inequality (A2-8) for the case of a rigidly supported bearing.
- b. Since $\Lambda_5 = \lambda_2$ is the only coefficient containing the recess depth, δ , as a parameter, the determinants Δ_3 and Δ_4 yield a quadratic and a cubic in δ . Consequently, unlike in the case of the undamped, rigidly supported bearing, more than one value of δ_c may correspond to the same value of the pressure parameter, $P_8 P_{ro}/P_{ro}$.

In the toregoing analysis, it was assumed that the external damping for the rotor, of mass m, was negligible. This, indeed, would be the case if gas bearings were employed as a means of lateral support, but no difficulty, other than an algorithm one, is involved in adding a damping term, $-c_2\dot{x}_2$, ω the left hand side of equation (A2-9).

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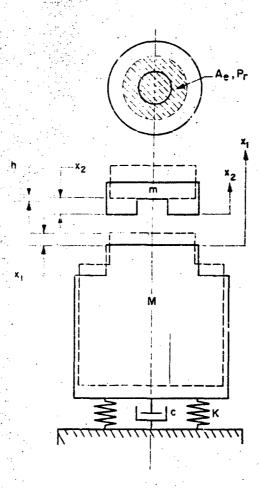


FIG. A2-1. SCHEMATIC DIAGRAM OF BEARING AND FLEXIBLE SUPPORT

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APPENDIX 3
BUCTANGULAR GROMPTRY - TAPILATION OF CALCULATED BUSULTS

23	(= 1 in
P	= 14.7 psia
P.	= 88.2 peio
	7. 1.65 × 10 ⁻³ lb-sec ² (in unit length.
1,	= 530° F abs
,	= 2.65×10^{-9} lb-sec/in ²
•	$= c_p/c_v = 1.4$
1.	$2X_s = 0.2 \text{ in}; a_N = 7.54 \times 10^{-4} \text{ in}^2$
II.	$2X_r = 0.1 \text{ in}; a_N = 7.54 \times 10^{-4} \text{ in}^2$
m	-2 9

Note: $\mathbb{F}_{\mathbf{c}}'$ refers to results of the simplified analysis.

Pro	P _s -P _{ro} /P _{ro}	^α c	δ,	δ΄		
psia	-	$\frac{\text{rad}}{\text{sec}} \times 10^{-3}$	in × 10 ³	in × 10 ³		
	1					
72.5	0.217	4.93	1.90	2.21		
75.0	0.176	4.82	2.65	2.93		
80.0	0.103	4.35	5.75	5.64		
83.2	0.060	3.75	11.8	9.70		
85.0	0.0376	3.19	22.6	15.0		
		П				
72.5	0.217	4.72	3.57	4.10		
75.0	0.176	4.61	5.17	5.63		
80.0	0.103	4.16	12.0	11.0		
83.2	0.060	3.58	26.2	19. i		
85,0	0.0376	3.02	. 54.1	29.7		
III						
72.5	0.217	3.26	7.45	8.55		
75.0	0.176	3.19	10.8	11.8		
80.0	0.103	2.89	24.8	20 G		
83.2	0.060	2.51	52.5	39.8		
85.0	0.0376	2.16	101.0	62.0		

(A4-2)

APPENDIX 4.

CIRCULAR GROWETRY - DETERMINATION OF CRIFICAL RECESS DEPTHS. TABULATION OF CALCULATED AND EMPERIMENTAL RESULTS.

When explicit expression of the coefficients C_i ; in equation (16b), are substituted into the characteristic determinant (31b) and the complex variable, s, is taken as equal to $i\omega$, the latter coal be written as:

ir. which

$$F_{11} = i \left[\frac{2 \hat{A}_{2}}{\Gamma_{ro} R_{r}^{2}} - \frac{m \Gamma_{ro} H_{o}^{2}}{144 \pi \mu^{2} R_{r}^{6}} (\alpha H_{o})^{3} \right]$$

$$F_{12} = F_{21} = i\alpha$$

$$F_{22} = -i \left(\frac{\alpha}{y H_0} + \delta + \frac{\alpha}{y} \right) - \frac{\beta}{2} \left(\frac{2 - \frac{P_1}{P_{ro}}}{\frac{P_2}{P_{ro}} - 1} \right)$$

$$G_{11} = -\sqrt{2} \frac{\partial Q}{\partial \xi} (5,1) + 2 \left(\frac{P_{at}}{P_{ro}}\right)^2 \left(\frac{R}{R_t}\right) \frac{\partial Q}{\partial \xi} (1,5)$$

$$-2\left[1+\left(\frac{P_{at}}{P_{ro}}\right)^{2}\right]\left(\frac{R}{R_{r}}\right)^{l_{2}}\frac{\partial Q}{\partial \xi}\left(1,1\right)+\left[1-\left(\frac{P_{at}}{P_{ro}}\right)^{2}\right]/\sqrt{\frac{R_{at}}{R_{r}}}$$

$$G_{12} = \sqrt{2 \frac{\partial Q}{\partial \xi} (5, 1) - 2 \left(\frac{R}{R_x}\right)^{k_x}} \frac{\partial Q}{\partial \xi} (1, 1) + 1 \sqrt{\frac{R}{R_x}}$$

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$$C_{21} = \sqrt{\frac{\partial \Omega}{\partial \xi}} (5,1) - 2 \left(\frac{P_{at}}{P_{co}}\right)^{2} \left(\frac{R}{R_{T}}\right)^{\frac{1}{2}} \frac{\partial \Omega}{\partial \xi} (1,1) + (1+\beta) \left(\frac{1}{2} + \frac{1}{2} +$$

In the foregoing expressions:

$$\alpha = \frac{12\mu R_r^2 \omega}{P_{ro} H_o^2}$$

$$\beta = \frac{1 - \left(\frac{P_{at}}{P_{ro}}\right)^2}{\log_e \frac{R}{R_r}}$$

$$\hat{A} = \int_{R_r}^{R} P_o(r) r dr \quad (Appendix 1.)$$

and $\phi(\xi)$, $\psi(\xi)$ are the variables in equation (40b), solutions of which, for discrete values of α and for $\beta=0.596481$, are tabulated in Appendix 7.

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Let the bearing geometry and the parameters P_{at} , P_{ro} , T_{o} , y and μ be specified. The gap width, H_{o} , can then be expressed in terms of P_{a} , the supply pressure, by equating the steady-state mass-flow rates through the nozzle and through the slot, e.g.:

$$R_{o} = \frac{\pi \beta P_{ro}^{2}}{12 \mu^{5} T_{o}} H_{o}^{3} = 2 \left(\frac{\pi d_{N}^{2}}{4} \right) \left[\frac{y}{ET_{o}} \left(\frac{2}{y+1} \right)^{\frac{y+1}{y-1}} P_{ro}^{2} \left(\frac{P_{+}}{P_{ro}} - 1 \right) \right]^{\frac{y}{2}}$$
 (A4-5)

Given a, the unknown parameters which appear explicitly in the characteristic determinant are Γ_s and δ , which must be selected in such a manner as to reduce simultaneously to zero the real and imaginary parts of the characteristic equation. (e.g., $\mathbf{g}_1 = \mathbf{g}_2 = \delta_c$ in equation 43b.)

This reduction was accomplished by trial and error, as shown in the following sample calculation.

Sample Calculation

Given:

$$m = 6.477 \times 10^{-2} \text{ lb-sec}^2/\text{in}$$

$$R = 2.5 in$$

$$P_{at} = 14.7 \text{ psia}$$

$$f_{\rm c} = 2.47 \times 10^5 \text{ in}^2/\text{sec}^2\text{-}^{\circ}\text{F}$$

$$\mu = 2.65 \times 10^{-9} \text{ lb-sec/in}^2$$

I.et

$$a = 0.050$$

and assume

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Then

$$\dot{v} = 0.1124 \times 10^3$$

and from Appendix 7 have:

$$\phi_1^{-}(5) = 0.3733$$

$$\phi_1(5) = 0.4772$$

$$e_{11}(5) = 0.3528 \times 10^{3}; e_{11}(5) = 0.6841$$

$$\psi_{\rm H}(5) = 0.9151$$
 ; $\psi_{\rm H}'(5) = 0.8906$

From equation (A4-3) have:

$$2 \frac{\partial 0}{\partial \xi}$$
 (5, 1) = 0.2640 + i 0.2020

$$2 \frac{\partial Q}{\partial \xi} (1.5) = 0.4860 \pm i \ 0.3788$$

$$2 \frac{\partial 0}{\partial \xi}$$
 (1, 1) = 0.5312 - i 0.1378

Equation (A4-5) yields:

$$N_o = 0.2069 \times 10^{-4} \left(\frac{P_s}{P_{ro}} - 1 \right)^{\frac{1}{2}} = 0.6019 \times 10^{-5}$$

so that

$$H_o^3 = 0.4096 \times 10^{-3} W_o = 0.2465 \times 10^{-8}$$

$$\frac{1}{0} = 0.1825 \times 10^{-5}$$

$$0.1351 \times 10^{-2}$$

and

$$(a \Pi_o)^3 = 0.3082 \times 10^{-12}$$

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The elements of the determinant (A4-1) then become:

For $\alpha = 0.050$ and $P_{\kappa} = 79.6$, the characteristic determinant (A441) reduces to:

$$\| \mathbf{v} \| = \mathbf{T}_{11} \mathbf{T}_{22} - \mathbf{T}_{12} \mathbf{T}_{21}$$

$$= \mathbf{a} (\delta - \mathbf{g}_1) + i \mathbf{b} (\delta - \mathbf{g}_2)$$

$$= -1.073 (\delta - 0.3668) + 2.279 (\delta - 0.3639)$$

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Results of similar calculations for other values of P are as follows:

$\Gamma_{\!$. g ₁	<u>g</u> 2 .
81.0	0.2550	0.3724
80.0	0.3274	0.3675
79.8	0.3455	0.3655
79.6	0.3668	0.3639

A plot of g_1 and g_2 vs. P_s , for $\alpha=0.050$, is shown in the appended Figure A4-1.

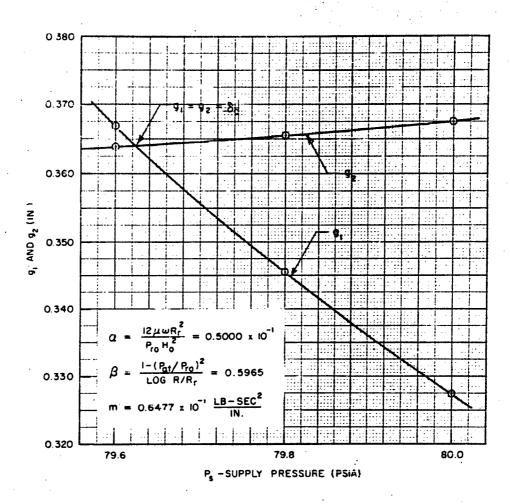


FIG. A4-I. DETERMINATION OF THE CRITICAL RECESS DEPTH FOR a = 0.050

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TABULATION \mathbb{T}^{2} CALCULATED RESULTS

PRESENT ANALYSIS

P,	P P_ /P	δ_c	٥,٠	
2-14		in × 10 ³	$\frac{\rm rad}{\rm sec} \times 10^{-3}$	
	I. m = 3.592 × 10 ⁻² lb-sec ² a			
. R2 R	0.127	143	1.55	
63.0	0.129	110	1.72	
23.1.	0.131	95.9	1.81	
83.2	0.132	90.0	1.85	
83.3	0.133	83.5	1.90	
83.4	0.135	78.1	1.94	
84.2	0.146	49.0	2.24	
I	l. m = 6.477	> 10 ⁻² lb-	sec ² in	
79.1	0.0803	2650	0.334	
79.6	0.0830	364	0.845	
80.3	0.0925	117	1.22	
80.6	0.0966	116	1.33	
81.0	0,102	90.1	1.44	
82.2	0.118	54.6	1.67	
82.8	0.127	45.4	1.75	
83.1	0.131	41.6	1.79	
83.6		36.6	1.84	
81.2		31.4	1.89	
85.2		25.4	1.97	
87.1		18.1	2.09	
89.6	0.219	12.3	2.19	
91.8	0.249	9.09	2.27	
93.8	0.276	6.96	2.32	
II	I. m = 11.68	× 10 ⁻² lb-	sec ² /in	
78.1	0.0626	273	0.769	
81.4	0.108	50.8	1.29	
82.4	0.121	39.9	1.36	
88.4	0.203	13.8	1.62	
91.0	0.238	9,60	1.68	

	2R	= 5 in
	2R _r	= 1 in
	d_{N}	= 0.055 in $(a_N = 0.237 \times 10^{-3} \text{ in}^2)$
	Pat	- 14.7 psia
ļ	Γ_{c}	- 73 5 peig
	T _o	= 530° Fabs.
	•	= 2.65×10 ⁻⁹ lb-sec /in ²
	у	$= \frac{c_p}{c_v} = 1.4$

SIMPLIFIED ANALYSIS

P _s	$P_{\rm g} = P_{\rm ro}/P_{\rm ro}$	$\delta_{ m c}$	ω _c
psia	-	in × 10 ³	$\frac{\text{rad}}{\text{sec}} \times 10^{-3}$
75.0	0.0204	158	1.05
80.0	0.0834	42.0	1.76
85.0	0.157	23.3	2.07
90.0	0.225	15.2	2.25
95.0	0.293	10.5	2.37

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TABULATION OF EXPERIMENTAL RESULTS

21 - 5 m

 $2R_{\rm p}$

Twelve 0.0167 in diam. nozzles (Total throat area = 0.263×10^{-2} in ²)

 $I_{\rm rec} = 172~{\rm Hz}$ (Theoretical load at $P_{\rm rec} = 5~P_{\rm at} = 73.5~{\rm psia}$)

I. $m = 6.477 \times 10^{-2} \text{ lb-sec}^2$ in; $P_{at} = 14.74 \text{ psia}$; $T_o = 537^{\circ} \text{ Fabs}$.

II. $m = 11.66 \times 10^{-2} \text{ lb-sec}^2 \text{ in}$; $P_{at} = 14.63 \text{ psia}$; $T_a = 536^{\circ} \text{ habs}$.

I				
P	δ _c	w _c		
psia	in × 10 ²	rad sec		
96.45	7.1	2242		
95.45	7.7	2227		
91.45	8.3	2214		
93,45	9.1	2185		
92.45	10.7	2153		
91.15	13.0	2126		
90,50	16.8	2076		
89,50	23.5	1987		
88.50	32.7	1884		
87.50	і б.0	1802		
86.50	59,0	1727		
86.05	69.0	1689		
85.75	89.5	1610		
85.75	122	1487		
86.05	1'6	1424		
86.50	170	1380		
87.50	200	1330		
89.50	244	1307		
91.15	274	1277		
93.45	293	1232		
95.15	302	1334		
97.40	308	1346		

$P_{\mathbf{s}}$	δ_{c}	س ر		
psia	in × 10 ³	rad/sec		
96,45	6.1	1713		
95.15	6.9	1706		
94.45	7.5	1699		
93.45	8.3	1684		
92.45	9.2	1676		
91.45	10.6	1647		
90.50	12.5	1621		
89.50	14.7	1590		
88.50	17.7	1552		
87.50	22.2	1515		
86.50	29.3	1471		
85.55	38.2	1421		
84.55	49.1	1362		
83.55	62.5	1313		
82.60	84.5·	1239		
82.10	107	1179		
81.60	147	1094		
81.60	206	1055		
82.10	290	929		
82.60	335	910		
83.55	405	873		
84.55	451	864		
85.55	487	857		
87.50	545	866		
89.50	590	873		
91.45	620	903		
93.45	635	908		
95, 15	640	937		
97 40	630	970		

APPENDIX 5

THE PURIODIA CHARGING AND DISCHARGING OF A WARIABLE-VOLUME RECESS

The purpose of this appendix is to investigate, at least qualitatively, the adequacy of the assumption that the process of alternate charging and discharging of the variable-volume recess would be represented by the iseatropic pressure-density relation P ρ^{γ} = constant to a reasonable degree of approximation.

In the course of experimentation, small amplitude auto-oscillations and sine waves have been viewed simultaneously and compared on the display of the cathode ray oscilloscope. Observed differences in wave form were slight. We shall consider, therefore, the case of prescribed, sinusoidal motion of one bearing surface and, making a series of simplifying assumptions, similar to those in Appendix 2, utilize the energy equation, instead of resorting to an a priori assumption of the pressure-density relation in the recess region.

In what follows, pertinent equations will be developed and linearized. Resulting perturbation amplitudes of pressure and density, as well as phase angles, will be related to those obtained when $P/\rho^2 = \text{constant}$. Numerical examples will be given for parameter values corresponding to representative points on the double valued, experimental stability locus I, Figure 55.

It will be assumed that perfect mixing of the entering gas occurs, but that fluid velocities in the region $V_{\rm r}$ are negligible and properties uniform throughout at any instant of time. Adiabaticity and equality of temperatures $T_{\rm s}$ and $T_{\rm r}$ of initially steady flow will also be assumed (e.g., $T_{\rm s} = T_{\rm ro} = T_{\rm o}$). The flow rates and their perturbations will be expressed identically as in Appendix 2.. implying the quasi-steady flow and lumped parameter approach to the problem. The fluid will be treated as a perfect gas with constant specific heats, e.g.:

$$\frac{P}{\rho} = f(T) + c_p - c_v; \frac{c_p}{c_v} = y$$

so that

$$\frac{\mathbf{u}}{\mathbf{r}} - \mathbf{c}_{\mathbf{v}} \mathbf{T} = \frac{1}{\gamma - 1} \frac{\mathbf{r}}{\rho}$$

$$\frac{\mathbf{h}}{\mathbf{r}} = \mathbf{c}_{\mathbf{p}} \mathbf{T} - \frac{\gamma}{\gamma - 1} \frac{\mathbf{r}}{\rho}$$

where u is the internal energy and h the enthalpy.

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The continuity and energy equations for the system shown in Figure A5-1 are as follows:

$$\pi_1 - \pi_2 = \frac{dM_r}{dt} = \frac{d}{dt} (\rho_r V_r) \tag{A5-1}$$

$$W_1 \underline{h}_s - V_2 \underline{h}_r = \frac{d}{dt} (\rho_r V_r \underline{u}_r) + P_r \frac{dV_r}{dt}$$
 (A5-2)

which can be written as:

$$\overline{\pi}_1 - \overline{\pi}_2 = \rho_r \frac{dV_r}{dt} + V_r \frac{d\rho_r}{dt}$$
 (A5-3)

$$W_1 = \frac{P_s}{\rho_s} - W_2 = \frac{P_r}{\rho_r} = P_r = \frac{dV_r}{dt} + \frac{1}{\gamma} V_r = \frac{dP_r}{dt}$$
 (A5-4)

The following dimensionless perturbation quantities are now introduced:

Let also h be prescribed as:

$$h = h_0 \sin \omega t = H_0 \cos \omega t; \ \epsilon = \frac{h_0}{l_0} \ll 1$$
so that
$$\overline{h} = t \sin \overline{t}$$
(A5-6)

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Mso, as in Appendix 2., we take;

$$\lambda_3 = -\left(\frac{\partial W_1}{\partial P_r}\right)_0 = \frac{W_0}{P_{ro}} \overline{\lambda}_3 : \overline{\lambda}_3 = \frac{1}{2} \left(\frac{2 - \frac{P_s}{P_{ro}}}{\frac{P_s}{P_{ro}} - 1}\right)$$

$$\lambda_5 = \left(\frac{\partial \pi_2}{\partial P_t}\right)_0 = \frac{\pi_0}{P_{to}} \overline{\lambda}_5 : \overline{\lambda}_5 = \frac{2}{1 - \left(\frac{P_{at}}{P_{to}}\right)^2}$$

$$\lambda_4 = \left(\frac{\partial N_2}{\partial H}\right) = \frac{\pi_0}{H} \overline{\lambda}_4 = 3$$

$$\lambda_3 + \lambda_5 = \frac{\pi_o}{P_{ro}} (\overline{\lambda}_3 + \overline{\lambda}_5) = \frac{\pi_o}{P_{ro}} \overline{\Lambda}$$

so that with:

$$\overline{w}_1 - \overline{w}_2 = -\overline{\Lambda} \overline{p} - \overline{\lambda}_4 \overline{h} \qquad (A5-8)$$

equations (A5-3) and (A5-4) yield:

$$\dot{\overline{\sigma}} + Q\overline{\sigma} - \frac{1}{\gamma}\dot{\overline{p}} - Qp = 0 \qquad (AS-9)$$

$$\dot{\vec{\sigma}} + Q \vec{\Lambda} \vec{p} = -Q \vec{\lambda}_4 \epsilon \sin \vec{t} - \beta \epsilon \cos \vec{t}$$
 (A5-10)

in which

$$Q = \frac{W_o}{\rho_{ro} V_{ro} \omega}$$

$$\beta = \frac{H_o}{\delta + H_o}$$
(A5-11)

and (+) = $\frac{d}{dt}$ = $\frac{1}{\omega} \cdot \frac{d}{dt}$ denotes differentiation with respect to dimensionless time, \bar{t} .

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In operational form, equations (45-9) and (A5-10) are:

$$((1+())\overline{\sigma} - \left(\frac{1}{\gamma}D + Q\right)\overline{p} = 0$$
 (A5-12)

$$D\vec{\sigma} + Q\vec{\Lambda}\vec{p} = -\epsilon(\beta D + Q\vec{\lambda}_4) \sin \vec{t}$$
 (A5-13)

where

$$D = \frac{d}{dt}$$

On the other hand, an assumed relation

$$\frac{P_r}{P_{ro}} = \left(\frac{\rho_r}{\rho_{ro}}\right)^{\gamma} \tag{A5-14}$$

yields

$$\frac{\overline{\rho}}{\overline{\sigma}} = \gamma \tag{A5-15}$$

so that equation (A5-3), with the aid of equations (A5-8) and (A5-15), reduces to:

$$\frac{1}{\gamma} \dot{\vec{p}} + Q \vec{\Lambda} \vec{p} = -Q \vec{\lambda}_4 \epsilon \sin \vec{t} - \beta \epsilon \cos \vec{t}$$
 (A5-16)

of:

$$\left(\frac{1}{\gamma}D + Q\overline{\Lambda}\right)\overline{p} = -\epsilon(\beta D + Q\overline{\lambda}_4)\sin\overline{t}$$
 (A5-17)

Operation on equations (A5-12) and (A5-13) with (D) and (D + Q), followed by subtraction, and operation with (QA) and (1/y D + Q), followed by addition, yields the following set of equations:

$$\bar{p} = \vartheta \frac{-\epsilon \left[\beta D^2 + Q(\beta + \bar{\lambda}_4) D + Q^2 \bar{\lambda}_4 \right] e^{i\bar{t}}}{\left[\frac{1}{\gamma} D^2 + Q(1 + \bar{\Lambda}) D + Q^2 \bar{\Lambda} \right]}$$

$$= \vartheta \frac{-\epsilon \left[(Q^2 \bar{\lambda}_4 - \beta) + iQ(\beta + \bar{\lambda}_4) \right]}{\left(Q^2 \bar{\Lambda} - \frac{1}{\gamma} \right) + iQ(1 + \bar{\Lambda})} (\cos \bar{t} + i \sin \bar{t})$$
(A5-18)

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$$= \frac{-i\left[\frac{1}{2}\left(\Gamma^{2} + O(1) - \frac{1}{2}\overline{\lambda}_{4}\right)\Gamma + Q^{2}\overline{\lambda}_{4}\right]e^{i\overline{t}}}{\left[\left(\frac{1}{2}\Gamma^{2} + O(1 + \overline{\lambda})\Gamma + O^{2}\overline{\lambda}\right]} + \frac{\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \frac{1}{y}\overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda})} \left(\cos\overline{t} + i\sin\overline{t}\right)$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4})}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4})}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4})}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right)}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right)}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2} + \overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right)}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right)}$$

$$= \frac{-i\left[\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right) + iO(P^{2}\overline{\lambda}_{4}\right)\right]}{\left((P^{2}\overline{\lambda}_{4} - \frac{1}{y})^{2}\right)}$$

O the offer hand, from countrion (A5-47) we obtain

$$\tilde{\Gamma}_{i} = \frac{-\epsilon(i_{i}T + i)\tilde{\lambda}_{4})e^{i\tilde{t}}}{\left(\frac{1}{2}\left(1\right) + i\tilde{\lambda}_{4}\right)} = + \frac{-\epsilon(i)\tilde{\lambda}_{4} + i\beta}{i\tilde{\lambda}_{4} + i\frac{1}{\gamma}}\left(\cos\tilde{t} + i\sin\tilde{t}\right) \qquad (A5-20)$$

In the foregoing equations, the subscript i denotes the isentropic relation assumed in obtaining equation (A5-17), and it refers to the imaginary part of a complex quantity.

The steady-state pressure and density responses to a sinusoidal displacement input:

are as follows:

$$\frac{\rho}{\rho} = \frac{e^{i\Omega} \left[(Q^2 \widetilde{\lambda}_4 - \beta)(1 + \overline{\Lambda}) - (\beta + \overline{\lambda}_4) \left(Q^2 \widetilde{\lambda} - \frac{1}{y} \right) \right]}{\left((Q^2 \widetilde{\lambda} - \frac{1}{y})^2 + Q^2 (1 + \overline{\lambda})^2 \right)} \cos \overline{t}$$

$$= \frac{e^{i\Omega} \left[(Q^2 \widetilde{\lambda}_4 - \beta) \left(Q^2 \widetilde{\lambda} - \frac{1}{y} \right) + Q^2 (\beta + \overline{\lambda}_4)(1 + \overline{\Lambda}) \right]}{\left((Q^2 \widetilde{\lambda} - \frac{1}{y})^2 + Q^2 (1 + \overline{\lambda})^2 \right)} \sin \overline{t} \qquad (A5-21)$$

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$$= \frac{e^{i\sqrt{\left((O^{2}\overline{\Lambda}_{4} + \frac{1}{2}/2)(1 + \overline{\Lambda}) + (O + \frac{1}{y}\overline{\Lambda}_{4})(O^{2}\overline{\Lambda} + \frac{1}{y})\right)}}{\left((O^{2}\overline{\Lambda} + \frac{1}{y})^{2} + O^{2}(1 + \overline{\Lambda})^{2}} \cos \overline{1}$$

$$= \frac{\sqrt{\left(\sqrt{2}\overline{\lambda}_4 - \frac{1}{y}\right) \left(\sqrt{2}\overline{\chi} - \frac{1}{y}\right) + \left(\sqrt{2}\left(\sqrt{y} + \frac{1}{y}\overline{\lambda}_4\right)(1+\overline{\lambda})\right]}}{\left(\sqrt{2}\overline{\chi} - \frac{1}{y}\right)^2 + \left(\sqrt{2}\left(1+\overline{\chi}\right)^2\right)} \sin\overline{t}$$
 (A5-22)

$$A_{1} = \frac{e^{i\left(\frac{1}{2},\overline{\lambda}_{4} - \overline{\lambda}/2\right)}}{\left(c^{2}\overline{\lambda}^{2} + \frac{1}{\lambda^{2}}\right)} \cos \overline{t} - \frac{e^{i\left(\frac{1}{2}\overline{\lambda}\overline{\lambda}_{4} - \frac{1}{\gamma}\beta\right)}}{\left(c^{2}\overline{\lambda}^{2} + \frac{1}{\gamma^{2}}\right)} \sin \overline{t}$$
(A5-23)

and, on the basis of assumption [A5-14], from equation [A5-15]

$$\overline{\sigma}_{i} = \frac{1}{2} \left[\overline{\gamma}_{i} \right]$$
 (A5+21)

The expressions for \overline{p} and $\overline{\sigma}$ contain the parameters ϵ , y, $\overline{\lambda}_4$, $\overline{\Lambda}$, β and 0, of which ϵ , y and $\overline{\lambda}_1$ are constants and $\overline{\Lambda}$ is fixed for any given set of pressure ratios P_s P_{ro} and P_{at} P_{ro} . We note, once again, the form of the parameters β and Q:

$$\beta = \frac{II_0}{\delta + II_0}$$

and

$$Q = \frac{\pi_0}{\rho_{r0} V_{r0} \omega}$$

Prior to solving equations (A5-21) through (A5-24) for a set of numerical values, it is of interest to consider the asymptotic behavior of \overline{p} and $\overline{\sigma}$ for limiting values of the "charge" parameter Q. We shall consider the cases when:

- (a) Q is a very large number
- and (b) Q is a very small number

white # remains finite.

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Case (it. () is very large

I chations (A5-21) and (A5-22) reduce to:

$$\overline{p} = -\epsilon \frac{\lambda_4}{\Lambda} \sin \overline{t}$$
 (A5-25)

$$\vec{v} = -\epsilon \frac{\ddot{\lambda}_4}{\overline{\Lambda}} \sin \vec{t}$$
 (A5+26)

so that

$$\frac{\overline{p}}{\overline{\sigma}} = 1$$
 or $\frac{p}{\sigma} = \frac{P_{ro}}{\rho_{ro}} = \frac{a_o^2}{y}$ (A5-27)

We note that equation (45-23) also reduces to:

$$\overline{p}_{i} = -\epsilon \frac{\overline{\lambda}_{4}}{\overline{\Lambda}} \sin \overline{t} \qquad (A5-28)$$

but since the assumption $(P_r|P_{ro}) = (\rho_r/\rho_{ro})^{\gamma}$ prescribes the \overline{p}_i and $\overline{\sigma}_i$ relation, we have:

$$\frac{\overline{p}_i}{\overline{\sigma}_i} = y$$
 or $\frac{p_i}{\sigma_i} = \frac{yP_{ro}}{\rho_{ro}} = a_o^2$ (A5-29)

In case (a), the following conclusions can be drawn:

- 1. The pressure-density relation is nearly isothermal.
- 2. The pressure and density are in phase and both are 180° out of phase with the displacement $h = \epsilon \sin T$. (e.g., increasing with decreasing gap width.) The coefficient

$$-\epsilon \frac{\overline{\lambda}_4}{\overline{\Lambda}} = -\epsilon \frac{\overline{\lambda}_4}{\overline{\lambda}_3 + \overline{\lambda}_5}$$

is a measure of the "static stiffness". The physical significance of the foregoing is that, if the motion is very slow (quasi-static), or if the mass flow rate is relatively large and the mass content of the recess region is relatively small, the changes occur nearly isothermally.

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i see this this very small.

equations (A5-21) and (A5-22) reduce to:

$$\vec{p} = -\epsilon y \beta \sin \vec{t}$$
 (A5–30)

$$\bar{a} = -\epsilon \beta \sin \bar{t}$$
 (A5–31)

so that

$$\frac{\overline{p}}{\overline{a}} = y \quad \text{or} \quad \frac{p}{\sigma} = \frac{y P_{r\sigma}}{P_{r\sigma}} = a_{\sigma}^{2} \tag{A5-32}$$

Equation (A5-23) also reduces to:

$$\bar{p}_i = -\epsilon \gamma \beta \sin \bar{t}$$
 (A5–33)

so that identically as in equation (A5-32):

$$\frac{\overline{\rho}_i}{\overline{\sigma}_i} = y \quad \text{or} \quad \frac{p_i}{\sigma_i} = \frac{\gamma P_{ro}}{\rho_{ro}} = a_o^2 \qquad (A5-34)$$

which was the assumed relation.

In case (b), the following conclusions can be drawn:

- 1. The pressure-density relation is nearly isentropic.
- 2. The pressure and density are in phase and both are 180° out of phase with the displacement h̄ = ε sin t̄. (e.g., increasing with decreasing gap width.) The coefficient

$$-\epsilon \gamma \beta = -\gamma \epsilon \frac{H_o}{\delta + H_o} = -\gamma \frac{v_o}{V_o}$$

is indicative of the "dynamic stiffness", such as would be the case of gas in a closed cylinder and piston system undergoing isentropic compression or expansion. The physical significance of the foregoing is that, if the motion is very fast, or if the mass flow rate is relatively small and the recess mass content is relatively large, the changes occur nearly isentropically.

To correlate the analysis with experimental results, the numerical examples were selected to correspond approximately to two points of the experimental stability locus I. Figure 55, for which the data are as follows:

		· 1	2
Р.,	рита	91.	5
Γ_{to}	reia	75.	9
Pat	psia	14.	7
To	tabs.	537	
ρ_{to}	lb-sec ² in ⁴	0.5722	× 10 ⁻⁶
П.	lb-sec/in	10	× 10 ⁻⁶
H _o	in	1.64	× 10 ⁻³
A_r	in?	0.7854	
$\overline{\lambda}_3$	- ,	1.933	
$\frac{\overline{\lambda}_1}{\overline{\lambda}_5}$	-	2.078	
\overline{X}	_	4.011	
$\overline{\lambda}_4$	- .	3.	000
y	-	1.	$4 (1/\gamma = 0.7143)$
E	-	10	-2
δ	in	13 × 10 ⁻³	275 × 10 ⁻³
ú	rad/sec.	2125	1280
$\mathbf{v_s}$	in ²	11.50×10^{-3}	217.3×10^{-3}
Q	-	0.7153	6.284×10^{-2}
β		0.1120	5.928 × 10 ⁻³

(A5-35)

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I varied

$$\begin{array}{lll}
\tilde{r}_{m} & \tilde{r}_{m} \sin(\tilde{t} - \phi) = \epsilon(-0.6792 \sin \tilde{t} + 0.1624 \cos \tilde{t}) \\
\tan \phi & = \frac{0.1624}{-0.6792} = -0.2391 \\
\tilde{\phi} & = 180^{\circ} + 13.45^{\circ} + 166.6^{\circ} \\
\tilde{r}_{m} & = 0.6985
\end{array}$$

$$\tilde{r}_{m} & \tilde{r}_{m} \sin(\tilde{t} - \phi) = \epsilon(-0.5291 \sin \tilde{t} + 0.2232 \cos \tilde{t}) \\
\tan \phi & = \frac{0.2232}{-0.5291} = -0.4218 \\
\tilde{\phi} & = 180^{\circ} - 22.87^{\circ} = 157.1^{\circ} \\
\tilde{\sigma}_{m} & = 0.5743$$

$$(45-37)$$

 $c = \dot{c} = 9.5^{\circ} \tag{15-38}$

$$\bar{p}_{i} = \epsilon \bar{p}_{mi} \sin(\bar{t} - c_{i}) = \epsilon(-0.7135 \sin \bar{t} + 0.1386 \cos \bar{t})$$

$$\tan c_{i} = \frac{0.1386}{-0.7135} = -0.1943$$

$$c_{i} = 180^{\circ} - 11^{\circ} = 169^{\circ}$$

$$\bar{p}_{mi} = 0.7269$$

$$\bar{\sigma}_{mi} = \frac{1}{y} \bar{p}_{mi} = 0.5192$$
(45-39)

 $\phi_i - \phi = 2.4^c \qquad (A5-40)$

 $\phi_i - \psi = 11.9^{\circ} \tag{A5-41}$

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(A5-44)

I xample 2.

$$\bar{p} = \epsilon \bar{p}_{m} \sin(\bar{t} - \phi) = \epsilon(-0.0911 \sin \bar{t} + 0.2248 \cos T)$$

$$\tan \phi = -\frac{0.2248}{-0.0911} = -2.468$$

$$\phi = 180^{\circ} - 67.93^{\circ} = 112.1^{\circ}$$

$$\bar{p}_{m} = 0.2445$$
(45-42)

$$\bar{\sigma} = \epsilon \bar{\sigma}_{m} \sin(\bar{t} - \psi) = \epsilon(-0.0611 \sin \bar{t} + 0.1625 \cos \bar{t})$$

$$\tan \psi = -\frac{6.1625}{-0.0611} = -2.660$$

$$\psi = 180^{\circ} - 69.4^{\circ} = 110.6^{\circ}$$

$$\bar{\sigma}_{m} = 0.1765$$
(A5-43)

 $\phi - \psi = 1.5^{\circ}$

$$\vec{p}_{i} = \epsilon \vec{p}_{mi} \sin(\vec{t} - \phi_{i}) = (-0.0923 \sin \vec{t} + 0.2322 \cos \vec{t})$$

$$\tan \phi_{i} = \frac{0.2322}{-0.0923} - -2.516$$

$$\phi_{i} = 180^{\circ} - 68.32^{\circ} = 111.7^{\circ}$$

$$\vec{p}_{mi} = 0.2499$$

$$\vec{\sigma}_{mi} = \frac{1}{\gamma} \vec{p}_{mi} = 0.1785$$
(A5-45)

$$\psi_{i} - \phi = -0.4^{\circ} \tag{A5-46}$$

$$\phi_i - \psi = 1.1^{\circ} \tag{A5-47}$$

Comparison of results of examples 1 and 2 shows that pressure-density phase angles are relatively small approximately 0.5° and 1.5° respectively. When the assumed relation is $\frac{11}{11} \frac{11}{11} = (\rho_p/\rho_{11})^2$, then is contradent to prescribing that the density and pressure he in phase. In example 1, the angle between pressures is approximately 2.4° and that between densities 11.9° . In example 2, the corresponding angles are very small; 0.4° and 1.1° respectively.

Since all angle, are relatively small, so that all densities and pressures are "almost in phase", a comparison of amplitudes is of interest as a criterion of validity of the isentropic assumption.

From example I we have:

$$\frac{\overline{p}_{mi}}{\overline{p}_{m}} = 1.01 \quad \text{and} \quad \frac{\overline{\sigma}_{mi}}{\overline{\sigma}_{m}} = 0.904 \tag{A5-48}$$

also:

$$\frac{\bar{p}_m}{\bar{\sigma}_m} = 1.22$$
, as compared with $\frac{\bar{p}_{mi}}{\bar{\sigma}_{mi}} = y = 1.40$ (15-49)

In example 2 the ratios are:

$$\frac{\overline{p}_{mi}}{\overline{p}_{m}} = 1.02 \text{ and } \frac{\overline{\sigma}_{mi}}{\overline{\sigma}_{m}} = 1.01$$
 (A5-50)

also:

$$\frac{\overline{P}_{m}}{\overline{\sigma}_{m}} = 1.37$$
, as compared with $\frac{\overline{P}_{mi}}{\overline{\sigma}_{mi}} = y = 1.40$ (A5-51)

In the foregoing examples, all parameters were identical, with the exception of the frequencies and the recess volumes. The ratio of the former was of the order 2; that of the latter of the order 1–20. Significantly, as might have been anticipated from physical considerations, the pressure and density amplitudes of example 2 were barely 1–3 of those in example 1.

For a sufficiently large volume, pressure and density changes in the recess, associated with small but finite motion, could become negligible. A very different condition, of course, would prevail in the bearing gap, due to the combined squeezing and trapping of the fluid between the nerrowly spaced boundaries.

fles its of calculations of examples 1 and 2 are illustrated in Figure 15-2.

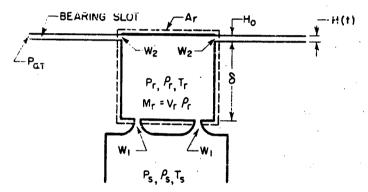
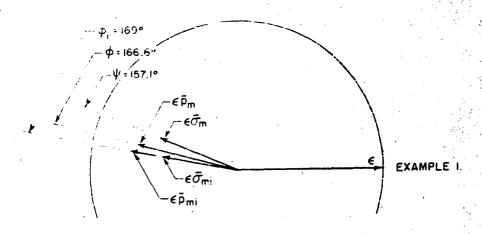


FIG. A5-1 SCHEMATIC DIAGRAM OF VARIABLE-VOLUME BEARING RECESS

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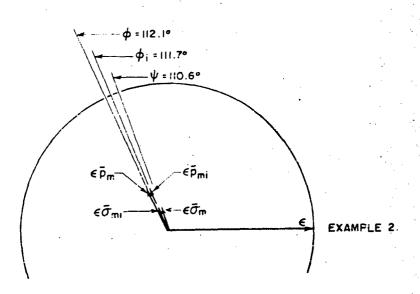


FIG. A5-2. AMPLITUDES AND PHASE RELATIONS OF PRESSURE AND DENSITY

APPENDIX 6

DUBLY VION OF THE DYNAMIC LUBRICATION EQUATION

The purpose of this appendix is to show that the differential equation (4) of the main text provides an adequate description of fluid-dynamical phenomena in the bearing slot, provided orders of magnitude of characteristic parameters fulfill certain requirements. The development follows mosely the method of Flood [45] who employed a small-parameter technique in the derivation of equations for gas lubrication.

It will be assumed that the fluid obeys the perfect gas law and that the specific heats, viscosity and thermal conductivity are constant. Continuity and constancy of temperature of the boundaries will also be assumed. In the range of pressures and temperatures considered, the foregoing assumptions are reasonable for gas flow in a narrow slot between metallic members.

The momentum, continuity and energy equations, stated in cylindrical coordinates, for axially symmetric, laminar motion, and the equation of state are [65]:

$$\rho\left(\frac{\partial \mathbf{u}}{\partial \mathbf{r}} + \mathbf{u}\frac{\partial \mathbf{u}}{\partial \mathbf{r}} + \mathbf{w}\frac{\partial \mathbf{u}}{\partial \mathbf{z}}\right) = -\frac{\partial \mathbf{P}}{\partial \mathbf{r}} + \frac{\mu}{3}\frac{\partial}{\partial \mathbf{r}}\left(\frac{\partial \mathbf{u}}{\partial \mathbf{r}} + \frac{\mathbf{u}}{\mathbf{r}} + \frac{\partial \mathbf{w}}{\partial \mathbf{z}}\right) + \mu\left(\frac{\partial^2 \mathbf{u}}{\partial \mathbf{r}^2} + \frac{1}{\mathbf{r}}\frac{\partial \mathbf{u}}{\partial \mathbf{r}} - \frac{\mathbf{u}}{\mathbf{r}^2} + \frac{\partial^2 \mathbf{u}}{\partial \mathbf{z}^2}\right) \quad (A6-1)$$

$$\mu \left(\frac{\partial w}{\partial t} + u \frac{\partial w}{\partial r} + w \frac{\partial w}{\partial z} \right) = -\frac{\partial P}{\partial z} + \frac{\mu}{3} \frac{\partial}{\partial r} \left(\frac{\partial u}{\partial r} + \frac{u}{r} + \frac{\partial w}{\partial z} \right) \\
+ \mu \left(\frac{\partial^2 w}{\partial z^2} + \frac{1}{r} \frac{\partial w}{\partial r} + \frac{\partial^2 w}{\partial z^2} \right) \quad (A6-2)$$

$$\frac{\partial \rho}{\partial t} + \frac{1}{r} \frac{\partial}{\partial r} (r \rho u) + \frac{\partial}{\partial z} (\rho w) = 0 \qquad (A6-3)$$

$$c_{pP}\left(\frac{\partial T}{\partial t} + u \frac{\partial T}{\partial r} + w \frac{\partial T}{\partial z}\right) - \left(\frac{\partial P}{\partial t} + u \frac{\partial P}{\partial r} + w \frac{\partial P}{\partial z}\right) = \frac{k}{r} \frac{\partial}{\partial r} \left(r \frac{\partial T}{\partial r}\right) + k \frac{\partial^{2} T}{\partial z^{2}} + \mu \left[2\left(\frac{\partial u}{\partial r}\right)^{2} + 2\left(\frac{\partial w}{\partial z}\right)^{2} + \left(\frac{\partial u}{\partial z} + \frac{\partial w}{\partial r}\right)^{2} - \frac{2}{3}\left(\frac{\partial u}{\partial r} + \frac{\partial w}{\partial z}\right)^{2}\right]$$
(A6-4)

$$\frac{\mathbf{p}}{a} = 8 \, \mathrm{T} \tag{A6-5}$$

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in which $a, k = c_p + c_v$, $y + \frac{c_p}{c_v}$ are constant.

The boundary coalitions are:

(A6-6)

Denoting reference quantities with ()* and dimensionless quantities with (), the following set of variables is formed:

$$u = \rho^* \nu^* = \text{constant}$$

$$\rho = \rho^* \overline{\rho}$$

$$T = T^* \overline{T}$$

$$P = \rho^* \left(\frac{\nu^*}{H^*}\right)^2 \overline{P}$$

$$H = H^* f(t), \text{ where } f(t) \text{ is } 0. (1)$$

$$r = L.\overline{r}, \text{ where } L = R - R_r$$

$$z = H^* f \overline{z}$$

$$t = \frac{L^2}{\nu^*} \overline{t}$$

$$u = \frac{\nu^*}{L} \overline{u}$$

$$w = \frac{H^*}{L} \frac{\nu^*}{L} \overline{w} = \epsilon \frac{\nu^*}{L} \overline{w}, \text{ where } \epsilon = \frac{H^*}{L}$$

(16-7)

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(16-7)

(8-6A)

also

$$\frac{P}{\frac{P}{2}} = \frac{P^* \left(\frac{1^*}{H^*}\right)^2}{\frac{P}{2}} = \frac{P^* \left(\frac{1^*}{H^*}\right)^2}{P^*} = \frac{P^*}{\frac{P}{2}} = \frac{P^*}{\frac{P}{2}}$$

$$\overline{P} = \frac{\nu}{P^*} = \frac{1}{\overline{P}^*} = \frac{\overline{P}}{\overline{T}}$$

In the foregoing $\epsilon=\frac{H^*}{R+R_*}=\frac{H^*}{L}$ is the small parameter used in developing

In transforming the equations of fluid motion into their dimensionless equivalents, the following relations between derivatives hold:

$$\frac{\partial \overline{t}}{\partial t} = \frac{t^*}{1^2} \qquad ; \qquad \frac{\partial \overline{t}}{\partial t} = 0$$

$$\frac{\partial \bar{t}}{\partial r} = 0$$

$$; \qquad \frac{\partial \tilde{t}}{\partial z} = 0$$

$$\frac{\sigma \bar{r}}{\sigma r} = \frac{1}{L}$$

$$\frac{\partial \bar{\mathbf{r}}}{\partial \mathbf{r}} = \frac{1}{L} \qquad ; \qquad \frac{\partial \bar{\mathbf{r}}}{\partial \mathbf{z}} = 0$$

$$: \frac{\partial \mathbf{r}}{\partial t} = 0$$

$$\frac{\partial \overline{z}}{\partial z} = \frac{1}{f \Pi^*}$$

$$\frac{\partial \overline{z}}{\partial z} = \frac{1}{f I^*} \qquad ; \qquad \frac{\partial \overline{z}}{\partial t} = -\frac{\nu^*}{L^2} \, \overline{z} \, \frac{\dot{f}}{f} \qquad ; \qquad \frac{\partial \overline{z}}{\partial r} = 0$$

$$\frac{\partial \overline{z}}{\partial r} = 0$$

so that:

$$\frac{\partial}{\partial r} = \frac{1}{I} \cdot \frac{\partial}{\partial \overline{r}} \qquad ; \qquad \frac{\partial^{2}}{\partial r^{2}} = \frac{1}{I^{2}} \cdot \frac{\partial^{2}}{\partial \overline{r}^{2}}$$

$$\frac{\partial}{\partial z} = \frac{1}{fH^{*}} \cdot \frac{\partial}{\partial \overline{z}} \qquad ; \qquad \frac{\partial^{2}}{\partial z^{2}} = \frac{1}{f^{2}H^{*2}} \cdot \frac{\partial^{2}}{\partial \overline{z}^{2}}$$

$$\frac{\partial z}{\partial t} = \frac{v^*}{1^2} \left(\frac{\partial}{\partial t} - \frac{\dot{f}}{\dot{f}} \, \overline{z} \, \frac{\dot{\partial}}{\partial \overline{z}} \right)$$

in which (') =
$$\frac{d}{dt}$$
 = $\frac{v^*}{L^2}$ $\frac{d}{dt}$

The dimensionless toom of equations (16-1) through (A6-5) then is:

$$\frac{1}{\sqrt{2}} \left[\frac{\partial \overline{u}}{\partial \overline{r}} + \left(\frac{1}{f} - \overline{u} - \frac{1}{f} z \right) \frac{\partial \overline{u}}{\partial \overline{z}} - \overline{u} \frac{\partial \overline{u}}{\partial \overline{r}} \right] = -\frac{1}{\epsilon^2} \left[\frac{\partial \overline{P}}{\partial \overline{r}} + \frac{1}{3} \frac{\partial}{\partial \overline{r}} \left(\frac{\partial \overline{u}}{\partial \overline{r}} + \frac{\overline{u}}{\overline{r}} + \frac{1}{f} \frac{\partial \overline{u}}{\partial \overline{r}} \right) \right] \\
= \left(\frac{\partial^2 \overline{u}}{\partial \overline{r}^2} + \frac{1}{f} \frac{\partial \overline{u}}{\partial \overline{r}} - \frac{\overline{u}}{f^2} + \frac{1}{f^2} \frac{\partial^2 \overline{u}}{\partial \overline{r}^2} \right) = (A6-9)$$

$$\frac{1}{2\overline{t}} \left[\frac{\partial \overline{V}}{\partial \overline{z}} + \frac{\partial \overline{W}}{\partial \overline{z}} - \frac{\partial \overline{W}}{\partial \overline{z}} \right] = \frac{1}{\epsilon^4} \left[\frac{\partial \overline{V}}{\partial \overline{z}} + \frac{1}{\overline{r}} \frac{\partial \overline{W}}{\partial \overline{z}} + \frac{1}{\overline{r}} \frac{\partial \overline{W}}{\partial \overline{z}} + \frac{1}{\overline{r}} \frac{\partial \overline{W}}{\partial \overline{z}} + \frac{1}{\epsilon^2} \frac{\partial \overline{W}}{\partial \overline{z}} + \frac{1}{\epsilon^2} \frac{\partial^2 \overline{W}}{\partial \overline{z}^2} \right] (16-10)$$

$$\frac{\partial \overline{\rho}}{\partial \overline{t}} - \frac{\dot{f}}{f} \overline{z} \frac{\partial \overline{\rho}}{\partial \overline{z}} + \frac{1}{\overline{r}} \frac{\partial}{\partial \overline{r}} (\overline{r} \overline{\rho} \overline{u}) + \frac{1}{f} \frac{\partial}{\partial \overline{z}} (\overline{\rho} \overline{w}) = 0$$
 (A6—11)

$$\frac{c_{-1}^{*} \cdot 1^{2}}{c_{-1}^{*} \cdot 2} = \overline{\rho} \left[\frac{\partial \overline{\Gamma}}{\partial \overline{t}} + \left(\frac{1}{f} \cdot \overline{w} - \frac{\dot{f}}{f} \cdot \overline{z} \right) \frac{\partial \overline{\Gamma}}{\partial \overline{z}} + \overline{u} \cdot \frac{\partial \overline{\Gamma}}{\partial \overline{z}} \right] - \frac{1}{\epsilon^{2}} \left[\frac{\partial \overline{\rho}}{\partial \overline{t}} + \left(\frac{1}{f} \cdot \overline{w} - \frac{\dot{f}}{f} \cdot \overline{z} \right) \frac{\partial \overline{\rho}}{\partial \overline{z}} + \overline{u} \cdot \frac{\partial \overline{\rho}}{\partial \overline{r}} \right] \\
= \frac{1}{\mu c_{p}} \frac{c_{p} \cdot T^{*} L^{2}}{\nu^{*} \cdot 2} \left[\frac{1}{f} \cdot \frac{\partial}{\partial \overline{r}} \left(\overline{r} \cdot \frac{\partial \overline{\Gamma}}{\partial \overline{r}} \right) + \frac{1}{\epsilon^{2}} \cdot \frac{1}{f^{2}} \cdot \frac{\partial^{2} \overline{\Gamma}}{\partial \overline{z}^{2}} \right] \\
+ \left[2 \left(\frac{\partial \overline{u}}{\partial \overline{r}} \right)^{2} + 2 \cdot \frac{1}{f^{2}} \left(\frac{\partial \overline{w}}{\partial \overline{z}} \right)^{2} + \left(\frac{1}{\epsilon} \cdot \frac{1}{f} \cdot \frac{\partial \overline{u}}{\partial \overline{z}} + \epsilon \cdot \frac{\partial \overline{w}}{\partial \overline{r}} \right)^{2} - \frac{2}{3} \left(\frac{\partial \overline{u}}{\partial \overline{r}} + \frac{1}{f} \cdot \frac{\partial \overline{w}}{\partial \overline{z}} \right)^{2} \right] \quad (A6-12)$$

$$\frac{\overline{P}}{\rho} = \overline{P}^* \overline{T} \tag{A6-13}$$

The boundary conditions are:

At
$$\overline{z} = 0$$
; $\overline{u} = \overline{w} = 0$, $\overline{T} = 1$

At $\overline{z} = i$; $\overline{u} = 0$
 $\overline{w} = i$, $\overline{T} = i$

(A6-14)

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(A6-15) †

Consider now solutions of equations (A6-9) through (A6-12) which can be expanded in terms of the small intermeter and follows:

$$\widetilde{\mathbf{x}} = \widetilde{\mathbf{x}}_0 + \epsilon^2 \widetilde{\mathbf{x}}_1 + \epsilon \mathbf{x} \widetilde{\mathbf{x}}_2 + \cdots$$

$$\widetilde{\mathbf{x}} = \widetilde{\mathbf{x}}_0 + \epsilon^2 \widetilde{\mathbf{x}}_1 + \epsilon \mathbf{x} \mathbf{x}_2 + \cdots$$

$$\widetilde{\mathbf{x}} = a + \epsilon^2 \widetilde{\mathbf{x}}_1 + \epsilon \mathbf{x} \widetilde{\mathbf{x}}_2 + \cdots$$

$$\widetilde{\mathbf{x}} = \widetilde{\mathbf{x}}_0 + \epsilon^2 \widetilde{\mathbf{x}}_1 + \epsilon \mathbf{x} \widetilde{\mathbf{x}}_2 + \cdots$$

so that

$$\bar{\rho} = \frac{1}{\bar{P}} \cdot \frac{\bar{i}}{\bar{T}} - \frac{1}{\bar{P}} \cdot \frac{\bar{\sigma}_0 + \epsilon^2 \bar{\sigma}_1 + \cdots}{\bar{\sigma}_0 + \epsilon^2 \bar{\theta}_1 + \cdots} = \frac{1}{\bar{P}} \left[\frac{\bar{\pi}_0}{\bar{\theta}_0} + \epsilon^2 \left(\frac{\bar{\pi}_1}{\bar{\theta}_0} - \frac{\bar{\pi}_0 \bar{\theta}_1}{\bar{\theta}_0} \right) + \cdots \right]$$

The functions appearing in equation (A6-15) depend in general on \overline{t} , \overline{r} and \overline{z} and are independent of r. The zeroth order functions are made to assume the boundary values (A6-14), so that approximating functions of higher order vanish at the boundaries. e.g.:

At
$$\overline{z} = 0$$
 : $\overline{V}_c = \overline{V}_1 = \overline{V}_2 \cdots = 0$

$$\overline{W}_o = \overline{W}_1 = \overline{W}_2 \cdots = 0$$

$$\overline{\theta}_o = 1 : \overline{\theta}_2 = \overline{\theta}_3 = 0$$
At $\overline{z} = 1$: $\overline{V}_o = \overline{V}_1 = \overline{V}_2 \cdots = 0$

$$\overline{W}_o = f : \overline{W}_1 = \overline{W}_2 \cdots = 0$$

$$\overline{\theta}_o = 1 : \overline{\theta}_2 = \overline{\theta}_3 \cdots = 0$$

Substituting the series (A6-15) in equations (A6-9) through (A6-12), the zeroth equations are:

$$0 = -\frac{\partial \overline{\pi}_o}{\partial \overline{r}} + \frac{1}{f} \frac{\partial^2 \overline{U}_o}{\partial \overline{z}^2}$$
 (A6-17)

Ti overs of e differing by two are taken since exponents of e in the differential equations differ on two.

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$$0 = -\frac{1}{f} \frac{\partial^{\frac{\pi}{4}}}{\partial \overline{z}} \tag{A6-18}$$

so I noting $f_0 = quation$ (A6-18) that $\pi_0 = \overline{\pi}_0(\overline{r}, \overline{t})$ only, the continuity equation (A6-11) yields:

$$0 = \frac{\partial}{\partial \bar{z}} \left(\frac{\bar{r}_o}{\bar{\theta}_o} \right) + \frac{1}{\bar{f}} \frac{\partial}{\partial \bar{r}} \left(\bar{r} \cdot \frac{v_o}{\bar{\theta}_o} - \bar{\Gamma}_o \right) + \frac{\bar{n}_o}{\bar{\theta}_o^2} \left(\frac{\dot{f}}{\bar{f}} \bar{z} - \frac{1}{\bar{f}} \bar{W}_o \right) \frac{\partial \theta_o}{\partial \bar{z}} + \frac{1}{\bar{f}} \frac{\bar{n}_o}{\bar{\theta}_o} - \frac{\partial \bar{W}_o}{\partial \bar{z}}$$
(A6-19)

and the energy equation (16-12):

$$-\frac{k}{C_{p,F}} \frac{c_{p} T^{*} \Gamma^{2}}{\Gamma^{*} \Gamma^{2}} \frac{1}{f^{2}} \frac{\partial^{2} \overline{\theta_{o}}}{\partial \overline{z}^{2}} = \frac{1}{f^{2}} \left(\frac{\partial \overline{U_{o}}}{\partial \overline{z}} \right)^{2} + \overline{U_{o}} \frac{\partial \pi_{o}}{\partial \overline{t}} + \frac{\partial \overline{\pi_{o}}}{\partial \overline{t}}$$

$$= \frac{1}{f^{2}} \left(\frac{\partial \overline{U_{o}}}{\partial \overline{z}} \right)^{2} + \frac{1}{f^{2}} \overline{U_{o}} \frac{\partial^{2} \overline{U_{o}}}{\partial \overline{z}^{2}} + \frac{\partial \overline{\pi_{o}}}{\partial \overline{t}} \quad (A6-20)$$

where in the penultimate step, use was made of equation (A6-17).

Integration of equation (A6-20) with respect to Z gives:

$$-\left(\frac{k}{c_{\mathbf{F}}\mu} \frac{c_{\mathbf{F}}T^{*}L^{2}}{\nu^{*2}}\right) \overline{\theta}_{0} = \frac{\overline{\Gamma}^{2}}{2} + \frac{f^{2}\overline{z}^{2}}{2} \frac{\partial \overline{\pi}_{0}}{\partial \overline{t}} + \overline{z}F(\overline{r}, \overline{t}) + G(\overline{r}, \overline{t}) \quad (A6-21)$$

and, applying the boundary conditions (A6-16):

$$F = \frac{f^2}{2} \frac{\partial \pi_o}{\partial \bar{t}}$$
; $G = -\frac{k}{c_p \mu} \frac{c_p T^* L^2}{\nu^{*2}}$ (A6-22)

so that equation (A6-21) becomes:

$$\overline{a}_{o} = 1 + \frac{1}{2} \left(\frac{c_{p} \mu}{k} \frac{\nu^{*2}}{c_{p} T^{*} L^{2}} \right) \left[\overline{z} (1 - \overline{z}) f^{2} \frac{\partial \overline{\pi}_{o}}{\partial \overline{t}} - \overline{U}_{o}^{2} \right]$$
(A6-23)

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Larging

$$I^{\bullet} = \frac{1}{I} \overline{I}^{\bullet}$$

be the reference velocity, corresponding to the steady-flow condition when $f\approx 1$, equation (A6-23) can be written in the following form:

$$\overline{h} = 1 + \frac{\gamma - 1}{2} \sum_{t} M^{2} \left[\overline{\tau} (1 - \overline{z}) \left(\frac{f}{\overline{\Gamma}^{*}} \right)^{2} \frac{\partial \overline{\tau}_{0}}{\partial \overline{t}} - \left(\frac{\overline{\Gamma}_{0}}{\overline{\Gamma}^{*}} \right)^{2} \right]$$
(46--24)

in which

$$N_{\nu_{\tau}} = \frac{c_{\rho} \mu}{k}$$
 ; $M = \frac{U^{\bullet}}{\sqrt{y \cdot c_{T}^{\bullet}}}$ (A6-25)

Since, generally, $\frac{y-1}{2} |N_{P_p} M^2| << 1$, one may assume that to the first degree of

approximation

$$\overline{T} \simeq \overline{\theta}_o \simeq 1$$
 (46-26)

which is equivalent to the assumption made in equation (2) of the main text, e.g., $P/\rho =$ constant. Equation (A6-19) then reduces to:

$$\frac{\partial \vec{\tau}_{o}}{\partial \vec{t}} + \frac{1}{\vec{t}} \frac{\partial}{\partial \vec{t}} (\vec{r} \, \vec{\tau}_{o} \, \vec{l}_{o}) + \frac{1}{\vec{t}} \, \vec{\tau}_{o} \, \frac{\partial \vec{k}_{o}}{\partial \vec{z}} = 0 \qquad (A6-27)$$

Integration of equation (A5-17) with respect to Z yields:

$$\overline{t}_{c} = \frac{f^{2} \overline{z}^{2}}{2} \frac{\partial \overline{\pi}_{c}}{\partial \overline{r}} + \overline{z} \Lambda(\overline{r}, \overline{t}) + B(\overline{r}, \overline{t})$$
(A6-28)

and application of boundary conditions (A6-16) gives:

$$\Lambda = \frac{-f^2}{2} \frac{\partial \pi_0}{\partial t} \qquad ; \qquad B = 0 \qquad (A6-29)$$

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so that:

$$\overline{\Gamma}_{o} = \frac{1}{2} \left(\overline{z}^{2} - \overline{z} \right) f^{2} \frac{\partial \overline{\pi}_{o}}{\partial \overline{c}}$$
(A6-a0)

Substitution of equation (A6 -30) in equation (A6-27) gives:

$$\frac{\partial \overline{\tau}_o}{\partial \overline{\tau}} + \frac{1}{2} (\overline{z}^2 - \overline{z}) f^2 \frac{1}{\overline{r}} \frac{\partial}{\partial \overline{r}} \left(\overline{r} \overline{\tau}_o \frac{\partial \overline{\tau}_o}{\partial \overline{r}} \right) - \frac{1}{f} \overline{\tau}_o \frac{\partial \overline{\tau}_o}{\partial \overline{z}} = 0$$
 (A6--31)

and integration between the limits $\overline{z} = 0$ and $\overline{z} = 1$ yields:

$$\frac{1}{\bar{\Gamma}} \frac{\partial}{\partial \bar{\Gamma}} \left(\bar{\Gamma} \, \bar{\pi}_{0} \, \frac{\partial \, \bar{\pi}_{0}}{\partial \bar{\Gamma}} \right) = \frac{12}{f^{3}} \, \frac{\partial}{\partial \bar{\tau}} \left(f \, \bar{\pi}_{0} \right) \tag{A6-32}$$

which is the dimensionless equivalent of equation (4) of the main text, when it is assumed that $\frac{1}{2}$ is a good approximation of \overline{P}

The error involved in neglecting higher order terms of the expansions could be estimated only if zeroth solutions were available; through substitution in the initial equations, for example. It is self-evident that the degree to which zeroth terms of ϵ -expansions approximate the actual functions depends on magnitudes of other coefficients which appear in the dimensionless equations of fluid motion. Of particular importance is the magnitude of f which characterizes the effect of boundary motion.

It was tacitly assumed in taking Taylor's equation [1] as the starting point of the analysis, and subsequently implied in the linearization thereof, that f was arbitrarily small. In doing so one was encouraged by the fact that equation (4) of the main text is exact in the limiting case, whenever:

$$L \rightarrow \infty$$
, with $f = \frac{L^2}{\nu^*} \frac{df}{dt}$ finite

or

$$H^* \rightarrow 0$$
, with $\frac{P^*}{\rho^*} \left(\frac{H^*}{\nu^*}\right)^2$ finite.

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APPENDIX 7

TABLE VIION OF COMPUTER SOLUTIONS

This appendix contains a tabulation of conputer solutions of the set of simultaneous equations (40b) subject to the boundary condition (41b). The solutions are for a fixed value of B=0.596481 and for discrete values of the parameter a. The range of the independent variable is $1 \le \xi \le 5$ and the interval size is $\Delta | \xi = 0.1$. The numerical method employed was that of Clippinger and Dimsdale and is contained in "Numerical Analysis", Kaiser S. Kunz. McGraw-Hill Block Co., 1957 pp. 206-208.

The following code is to be used in reading the tables. The first digit is zero if the number is positive and is a minus sign if the number is negative. The second and third digits stand for 50 + n, where n is the exponent in 10ⁿ. The remaining digits represent a decimal, which must be multiplied by 10ⁿ in order to read the required number.

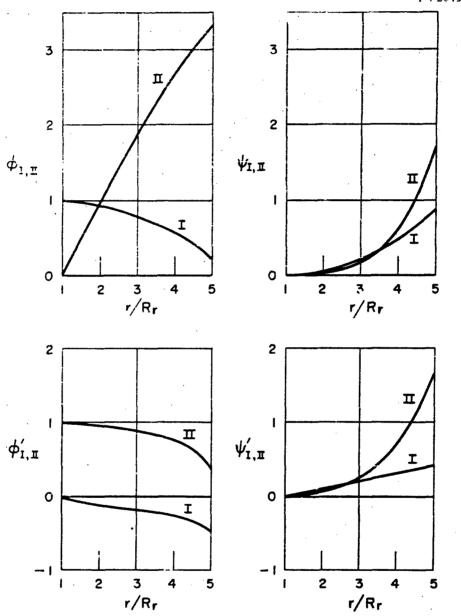


FIG. A7-1. PLOT OF COMPUTER SOLUTIONS OF EQUATIONS 406 FOR a = 0.093

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050996641948 449227442140 -FRZA6470756 046504434540 048101405201 040102745262 051120000000 0900055#1747 #49416169836 #F71/2#46210 547203857113 049705381741 049105103931 3514 30005000 050990645025 =49575363250 =40146544234 047441414724, 348311519348 040107175795 351140005000 C5C4841=3327 =49710463019 =50105559015 047-27544262 046414638996 050104024516 051150000000 050976-95500 -49827717110 -5010850888 048130004116 04852949-635 010111435982 CELIADOCIONO 0509676ECA4# =49928995152 =40945193796 048198887157 046640982734 040112223666 USINTACCOTAC C400574-A256 -50101753741 -448589492961 04854844946A 048753966190 640113A36785 USINE CODACC 0436:7740400 -50109440630 -4497313901:3 0463398:3615 046868710632 049114037404 URITARCOS COS CACESSY MCD70 -50116451014 -49648770350 048432120052 048983785154 040116157937 051200003100 050q24174890 -50122556554 -49575247064 04855830410 049116046264 04611750554 oftpinopping GSCG115,0480 -50126028755 -495:74:0963 046642252750 049121844741 040118390609 051220000000 C5CP08:47984 -50132936201 -409461;6762 048780008873 049153726561 040119422770 G51230000000 GSGRR40:5330 -50137356886 -49419503007 048919615410 049145730721 049120/04065 051240000000 CRC#71/ RC#74 -50141745381 -49379461734 049167150242 0491570F6234 040121761025 051250000000 05UR56618438 4501449U3829 449344865820 049123829205 049189989106 040122278170 04/A42149121 -50146249200 -440313441123 C44141153083 C4914224113C 040123142430 C50827085398 -50151246835 -89286129343 OBC1800877008 0491046*2909 060124054841 JSIZANDODADO G5C#11568449 #50153981968 #19241746611 G49180059593 049207473867 5.0124017406 ,412900000nde C5079A2x1985 _50156489A85 _L92x0035019 04620140A702 C49219000676 0.0125025498 051300000000 USUTROSITUTO -50155790749 -49220A25872 QUAZZUNTO570 049232249297 040125719704 051310000000 0507545:4110 -50160908535 -40203751842 040247854951 049244483735 040127827799 351320000060 050748381272 450162860969 46918783414-** 1495 049257745862 040128571733 051330000cc C5:7519#0045 -50164A66227 -19173A13372 1. ~~+270078223 non129453212 3513400GUCCC 050715412444 L50106137945 -L91A1012847 0443271 - 200 089783070379 0L0130895762 CRCA984a90) R -50167890500 -49149A73833 049384158337 049296708731 04913170A858 0513/0000000 351370000000 CRCARUSS7548 -50170A83494 --9130330764 049448163152 049373384477 040134537997 GSIBAROCORDO C4UA477A4148 -50171045034 -49172134073 046441130540 049336874265 010135A99187 051390000000 051400000000 C5CA13CB0A54 -50174244080 -49168323879 0495213 1391 04974434968 040134710342 051410000000 GSGS95507448 -50175047732 -49102409708 040544413255 0493783-0271 040141357438 051420000000 040-790-2847 -59176598787 -48976513140 04950498194 049392643296 04014385206: 041430000000 GAG#AG3#0790 -50177253302 -##8944807105 049A36944310 0494071A7197 040145420204 051440000000 CACE42573460 -50178169892 -48699415776 049678429481 049422017079 04015 1972236 G51#50G03000 CRD#24769446 -50179054990 -48672719612 049721343630 069437246472 040154709962 0514A0000000 05C40A7A3525 %50179018179 ~44884402194 CL97A5H34121 049L52974796 0L0160120075 051470000000 C5C4887-8478 -501H0767296 -48845913233 3498126:0175 047469334338 040167040792 351460303000 C5C47066984A _5C181614659 _48849580673 C49849792769 049486477163 040176188339 35149n000nnn 050457445905 -50182471557 -448649454037 040900558765 049504658340 8:4555020777 C5Cu3414457 _5C183761597 _48914409488 0449AC750535 C49524441938 C40207447055 051500000000 051510000000 090415742509 -90184310761 -4910390472 050101333250 049546464415 049237673822

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ინესიტიდებით დემებილი გომ ცლელიდილიდან და ენებილიდით გიისტიტიტი დეგილიდი<mark>თ დამილიდითბან დაგილიდით</mark> af Extendioned CUPAGE A SIR USCHMAINING WEGSMARS9204 GREINAAGSPRE CRESCOBREZEC GURIOZAGRIAI CAUTION CHESTON TREATMENT TEBANTETAND CONCERN CAUTION CONCERNS CAUTION CAUTION CONCERNS CAUTION CAUTI \$51120000000 351150000000 2402991#.A72 250992118725 -#94#2422375 046#44956A39# 04747537133# ###325017371 050398191528 650987341605 ado507820672 Outijzane065 gu7839386138 gu#443870961 151140000000 050496503144 050962030910 -40541795752 047292042818 048136901436 740997850775 351150000000 C405945:5575 C5C976356171 -L05AC697571 04734985#341 C481990#1757 @URB97#C56#3 351150003000 Jan to Counce 050A91A47215 050970453610 -495988A6191 047528494210 048274947950 04831434796 CALLANGOSAAA C4CTRR6A1A34 C5C964411149 -40668A06373 CAT94A438777 C483A64F7446 868971-90HAU S**kiljendr**okim asiathoconon 040040240361 050952167797 =#0612910208 04#1#395*238 04#5#900#031 duet2s*10958 351211003000 051220003000 051116747;79 05093997835A 449664596337 04835454596 04887543388 049156756312 0512300000000 C41126316017 057933906475 -49597547603 048497497875 0491C4447698: 049176758714 C5113504AR70 05092803GRAS -49589444904 048543751518 C49122715379 049193850838 251240000000 ¹¹ 091144577231 050922180700 ...05x0915915 04xx7x47x470420 049143443669 044412.442046 051250000000 C41150 90991 05091A022302 -0057105077- 048030652490 049165241653 040231469364 351260000000 CALLASZAAKOR C50910700AUA405x1071854 C44107064482 C441894474C2 644252197125 \$41270005000 35,280000000 0511727=4533 050905197433 -44541930444 040191614113 049215723556 040273499440 041290000000 C41181310894 050899734115 -49541357594 C46449681964 C49244182428 044295850628 G51300000000 C511902#1347 050894370557 -49531453422 040140417063 C49274944223 040319978139 351310000000 Chilabiana, Careeliusus -49521407439 C40100440252 049308140151 040344164021 051320000000 951330000non Signed action of the contraction 05.1225601276 050873876600 -49493908660 049368161688 049423468144 646427949364 051340000000 551350000000 C51234145494 050568981240 249485202040 04938257552 049487795576 04045855539 3513A0000A00 051243-21152 05-864169705 -49477063306 049401624107 049515342380 049492455779 US1370000000 C41241449152 C50859438475 -49449249268 04944988787 049556389465 040528454465 ost sancountin C512602102:6 050854782977 -49441918340 040515252112 C49621178917 040567422847 C412A8744064 050850198545 #49445083269 049586957436 049650094045 @wohogenigage 051390000000 051400000000 051410000000 0512856#8860 050841230#60 -#9443[40128 040729076390 049811309535 040706537849 051420000000 051294048982 050836814350 -49458-A8607 0498(3643003 0498848#5837 046763928428 051430000000 051302345309 050832454525 _49433988052 044904546705 04996#2#869C 049826429333 051440000A0A C513106##197 C50828131510 _L943C731012 OSC100#92557 C501C50#5462 QU0499223772 051450000000 C517189uAn45 050823836370 _u4428480652 050111490028 C50114428636 044983762035 051440000000 C513271A4973 C50819555330 -49497800257 O5C1934C8171 G5G12474821C G5G107754637 351470003060 051135319173 050615274855 -49438783874 05013684 050136841677 050119173467 05140000000 051343470397 050810v-1479 -49432149277 05014085951 0501486575711 PRE13374-1494 051490000000 051551548490 050AC6A21395 -49438908918 0501AA421061 050162973115 050152359614 051500000000 0514596n2505 050802173295 -494513A0577 050;4541415 0501793R0661 05n177964112 00000001010 051367661592 050797570270 -449473868491 050202483755 050198841821 056217001079

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351110000000 050000821150 _49227143886 _8020827152 04710007x240 048202809750 040205490215 1051121000000 050995581702 -49416113763 _<^172842674 087467326925 04541J722673 046210207840 051130000000 CACCOGCEAUBOS -40575577625 -45146850304 047023827440 048623058070 040214551552 351140000000 CSC084182050 _46716099337 _5A195566736 CHRIAGU74386 048839247296 049218748942 151150000000 050976486200 =49827805710 =40100983825 04826454358 0491059(213H 049221492759 2511Ancoonco CS_QATABRUBA _49929121984 _44945856930 048177401286 C49128106625 049224446745 351170000000 050457304440 -50101774381 -449824887501 048514801940 049150781246 049227260609 251180000000 CSC647399136 _50109472388 _40731849101 048679634199 0491736:2000 040229873161 051191000AC6 050656049840 450116477028 446650013495 00004494680 049196750703 Muc232713222 050a241a3110 _50122421100 _40580337999 049107351449 049220009746 049234407041 de Labordope de 05C011517265 -57128116819 -49527227565 040130651091 749243648366 089236774945 381210000000 051220000000 SSCROB-ERRIB -5013305323 - ERGRADARED OFFISACOSISE 049267441167 086238836294 J512300000000 040284072598 _50137408679 _uq423370422 049183023252 049291448459 049240796057 351240003000 05UR707A6712 -5144540104 -493A4224291 04924400656 049315667855 049242703501 051250000000 050856563190 45014570834: 449347975034 019247537667 049379991545 049244531048 0412A0000000 040P4194575F -50148453587 --0319976426 0497F734380 0497645-2527 649246331144 251270000000 CACADAHO9745 -50151619171 -- 0207407422 049740071367 C49389242273 A40246493998 25 (250000000 CSCR11690187 -50154436094 -49270403675 040360160349 049414178757 040201775302 CTCTTSTS4054 -50:57035700 -4492499A6560 0494028CT004 0494392:5730 049251472709 3512400000000 051300000000 C5C7802+94:2 450150493583 4//0231089133 049448600312 049464943814 049253338139 as ratinggangs 040744104345 _50161462507 _60216176092 046498704602 0494898#1617 040255126949 G51320000000 CSC7479#7854 -50163773410 -49202323665 040545072185 049515471005 049256950046 OSE SOCIOCOCO C5C731369615 -5C165734534 -4019026352 0405988C6785 0495414779C5 0442589C1819 0513400000000 050714744712 -50167583555 -49179743159 049654254347 049567244817 040260035274 35135000000 650A97449780 -5016933429A -491767A1528 049717765015 04959344764C 040263A96504 DESTANCADAGA 04CFF0#00414 -5C171003479 -401A3148334 040777954364 049619279814 040265435009 051370000000 C5C643f037f5 -5C172A01824 -49156890284 34988A247615 04964A5A0460 A402A7A83A33 051381000500 C5C646342138 -57178145-72 -42181867933 089902276399 069673485897 ABC270006440 051390000000 CSC#28HAR739 -50175443501 -49148126768 04997050683 049700731810 040273059479 051400000000 C93411294480 -50177112160 -49145415781 050104949397 049728201415 040277#35856 951410000000 C50493449655 -50178459810 -449144375156 350111861397 049756246050 Q40281838616 051420000000 C40475592708 -50180004197 -40144478663 050119340997 049754641434 040286410262 051430000000 0505574#1630 -50181453892 -49146025454 050127454544 049813546585 049292542131 051440000000 050439241144 -50182050035 -49149498609 050135643393 049843087155 040298789399 GS1450000000 050520848170 -50184443659 -449154243987 050144216175 049873374085 044307030839 55144n000non C5GF023uC351 -50186022502 -491A1576008 05C153113961 0499045A1048 04931729K022 051470000000 C5048364649 -50187683962 -49171789948 050162906077 049936927450 046330441549 051480000000 CSCUAU769503 -50181 171318 -49185928904 050171857599 049970790637 04934780A674 *********** 051500000000 050426587577 -50193415426 -49234450141 05019200-477 050104544373 049407302775 351510000000 090407094898 -50196150701 -#9280540487 05077464778 05010870335 000445577733

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3511300000000		0502491-1761	C51:492118015	-49442A20806	047211050964	048213917368	049146758036
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351170000000		CRCASIFEROSE	050970429.35	-400000000000	048281956095	0491242)5922	040374143905
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091740000000		041145614394	050927553084	-49604532616	049244475226	049552292334	n496/2947725
35,950 0 00000		0-1144-49812	050421432345	-JQ>497#1812	049304429275	nu964361993C	040-55269035
051260000000		051156785175	050915456424	_49595336634	049373494194	749743571021	05-1643236P7
341270009600	•	091163171115	050909473540	Jan5a (413534	04945424771	047652451245	04/113/163737
351280300000		64.1727.47777	050903722607	_19588473045	049544494370	C49970643767	05 123739642
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351510000000		051199-#5234	050866101790	a -9588594737	049895450045	050178618305	r5r15478450S
351320003000		UN1207714473	C50880197935	-47592342447	050104919563	050154679993	n3r166F37571
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351550000000		C51274747134	C50862085710	-4019698166	050158666683	C5C210415372	04~206259338
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ეკარა გესგურებები რებარტების ანარტარები ბუფოფა<mark>რ997</mark>AC UNUNYBO31737 -4922/345.15 -E0204383/25 C4745224657 G4050/U15145 646513926286 בשרקב לישור בשרקה בארונים בלציאשון הרכשים ברשישון במיישור במיישור במיישור ביישור ביישור ביישור ביישור ברשישון ביישור ברשישון ביישור ביי JOSESHOUSE 030904250564 46971,249719 469126700755 546414674587 649269814557 64555720657 CPUPACE #5647 UNIQUE - 10762444 - 449644444 CPUPACE - 440444 CPUPACE - 4404444 CPUPACE - 440444 CPUPACE - 4404444 CPUPACE - 440444 CPUPACE - 44044 Ca Markedear aungertabhe ar Grafaranti nialentahar manana 194, 194 empirahasean CROST TO BE TO THE CONTRACT TO THE STATE OF THE STATE OF THE SECTION OF THE CONTRACT CARREST CONTRACTOR OF THE CONTRACTO .5.4 /0000000 C3074337512.5 L3C177C73175 LEFF-WW15442 C494661313W WEFF5C476314 C40560446476 .5180000.000 23.2.000000 ->1240000000 C3U804346715 120136573142 1894254465090 049489637423 048729328050 040001756327 COURT JULIEU HINGLIGH STEIN OF HIGH COUNCY THE STEIN OF LIGHT SOUN HINDS SELF C Chicaeliescus aunipunghun, auraced/91/c neg/0567450 Ga911119678 Ca96137.5375 201200000000 C3.04-07724- 43015-231701 40934-50004 0467896-8231 669472372866 (4601381185 -314/0000000 ULUMUS PROMET PUNGS/615575 PERPANDENNE NEGOCIALIZA, ESELECA-99858 CENCERSSSOOF 33.270000000 Cantamorpha moutenagen meratembati vanitigenteen montigettaling (14095)495946 Caurranaman mantamerama menathanra nachtiyanan uputtecetrik canadiktanna COURTED FOR TOUR STORY TOURS AND TOUR PROPERTY OF CONTRACT USER SECTION OF CONTRACT CONTRACTORSناتاناتهدادا UBUTEUUTADUS -UNITUSULETE -+++51000/11/5 0502/3484442 UBUTELQ45224 04004/854034 -2124000000 COURTERVENO -- -- 1734 17365 - 4714290170 050,7794 551, Coulterin 1676 Carusziacja _3436000000000 UJUDZHARUZZZ HUNIKANIKATADIS HEGSKYNEZHON NOULOSIZADO, UNUISKURNZZA NUNGOUMIROIMA ,543,000,000 J3.30000000 COURTINGTON AU - 0257023 -69361050745 050282505469 050174051262 046672559786 _314400000000 UBUSTRIADUS ABRUSTURS AND STANDARD CONTRA HERMUNDE PARTO STANDER UBUSTURS CHERTURS CONTRA CON U307/041780// 02/2/137627/ 04:030261020 //562/26///4265 05016:122127 60/08/2465-4: -31460000000 USUSBULEBALT LONGINGER 11 - MANUFACTURE OF 100 1100 1 - MANUFACTURE OF LONGINGER OF LANGUIS OF LANG _>44200000 UNUNITORIONY -- M210715281 -49862816784 05033930746 USUF316731 UH0712776351 -34470444444 CRUMMANAUNA -JM22-127496 -49441664181 MSUA960355, USUFFICAMANO U49723A330FG 131-20111100 Caralinaala =30558984717 -86893610465 020341044820 62455 180004 (844/4125-11) -514 (0000000 -218 70 50 5000 しつよういいししいいい כפעטוישנחשת. שוכחדב בפנים באפוונגדר שבח שנחיצונים מהחצונים מחוצו בחבר אווצוננים בווצוננים ביוצונים ביו CARTER SERVICE CONTRACTOR STATES OF CONTRACTOR CONTRACTOR CHARGES OF CONTRACTOR STATES

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CHARAROCCODDU 177, 103015510 -# 1504223131 UMPOSHED15CO CH122445842 OHESTATICIE -----CONTRACTOR UNVAINDANCER -BILLEWASTONES UPPORENTED CHAIRSTERS OF GLOST PER CHAIR OF CONTRACTOR UBUKTY-41121 M2049411144U -449142645U31 0472745289, 444271485447 04016250894 J34, 4000 3000 -341-000-000 COMMENDACELLY COUNTRICATION PROGRAMMENT UPPRETAMENTS CHANNER CHANNER CHASSIFF CHASSIFFER Cambrantstate wheathathat anyotistates unmindestand medeblesses of estimations .344/1 Camerianayur "anir 423410 -04400303103 048513219963 Cmaiseurifit Canalaridade CBUTOL TARRON LOUANNESSMIND OF INTERESTING LABOLL BETWEEN CHARMANING CRAIGSTLABASE CHARMANING FOR Jake William Co. CONSOURCEST COMPOUNTATION AND ELECTRONICS CHANGES TON UNIVERSE FOR COMPSSO 174015 COUNCIONETTI, CONY COSCEPT - HUNE MERCHOST MERCHOCARET, CHORA LOUGHON CHOCS 49374+4 COLLUNGIONE CONTRACTO CONTRACTO CONTRACTOR C Becatering transference and attended to the second of the COLEGE CONSTITUTE CONSTITUTE CONSTITUTE CONSTITUTE CONSTITUTE CBLINNUBBOOK CUCAPIBIRANG WENNESDAME MENINGRAMMA CHAPTIBLEIGHT CORECUMBERA COLINGORIA TON PORTO CONTRACTOR C 1377/1000000 הומסטובורט השבה בי בי בשנ או הושים בכב שונים בי ביו ישור בכב של בי ביו ישור ווכבים בבים בים בים בים בים בים בי COLLIZERS TO CONSCIONATION - HESTROOME MARCHARMENT COLLONG OF 1367COURS CONTRICTOR AND COURT COLUMN TO LEAD AND TOTAL OF THE CONTRICTOR CALL CALLED AND THE CONTRICTOR CONT 436179437634 FUNDHU368395 -68464566616 FREEDST-65-19-41244F 05-171657387 C3.4070003300 C30077277500 0096121510447 050.15776003 050171845100 (156183008066 Charletones constituent in Medio/m/s oscissons a charletones oberesesuit 4242400000000 Conditioner Condition - Condition - Condition - Conditioner Condition Condit U3143916534 CUNGAL394499 -6365855753 NSC.7636NDC. U5U23314916 C272693U3476 ביניבל בשבים לעלותב לבעילי בשל שנשם מונים של היו בל ביש לכל מחום בינים ב -313/0000000 COLEPTICATION CUMBILIARIA ONE OLIGINATION MADERITARIA COLPTRIAMA C C31234483073 F3F87/87/87 -889738533780 F3C49756941. C5C41C4F1534 C3F283AC9547 Calabrusabur Cun634161150 -497/44/4411 050489994147 C50537075707 C50503035431 ********** 43.2/042/4JM C20324180+13 -8482/63/744 0303/7513013 454971281889 65752674 PESSENCE TURRUCCONLED COULENALUEN PRESENCIA DE 1764 TOLIONE SCOTSCHOLOGU . 21446664 66 UBARYENJEGOS CANDRIGESTARA ARBODOLINALIA CECARGOANTEL CECARECAREDA CENTARENTE ~3447000UVVC COLDECTION TO THE PROPERTY AND THE CAMPACE CAMPACE COUNTY 1344000000 ביישור לביישום לביישום לביישור ביישור לביישור לביישור לביישור ביישור לביישור ביישור לביישור ביישור לביישור לבי 45447000000 ,74400000000 CBLD45aHUDUN CUOTBURYTYMU MAŬINTETONEI OSCOTTLINUM DOUBLEMBRINE ESPESSIVILAS 124470000000 הינבצלים מוללכנול המוללנולה במונים במפלונים בכינים מולים מנונים ומונים ומינים במולינול בניבט -2140046444 COLUMN 11 INTOPP TURE SPECESPICED OBJUSTICAL STRINGS TO THE STRING STRINGS -214 TV-00-00 63+345949431 C3076419HU40 -40717965317 05047674474 65040704 05474468447 ,243, ,,,,,,,,, CBASIKEMSANA COMBANISSING ABOZEMO/4016 MSUVESTAMUS/ USUMPLUPROS7 USMB/JASASES -3.3.vvvvvv PAGGITON ALLEGANDES - PELLEGAN MARTINE CONTROL OF TREGULARIAN COLLEGAN CONTROL CONTROL

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3511A0003/ 70	Chuq67639154	9430475045	9942947593	049117212161	049384567963	040673326784
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25119000000	193035914853	-50116967997	-49047942528	C49259270116	049590518695	049696959779
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G51240000000	090870285675	-50143417037	9433428763	^49642#51291	~699465#12CC	044727421498
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05136000000	. C50A705423 ⁷ 9	-50168791171	-4941544830#	050211487597	050185474729	044783734012
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US139000000	CRUA 12:#6585	-5C2Q2447575	_495n2##2166	050290861881	050209174001	040798738079
651400C000CC	050=915=0672	-50207440744	-49542679026	050312186335	0502171=1872	04904306149
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051480000000	C404928e#168	-50273030437	-90125942: 36	050512424545	090284367887	040897363237
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351110000000		-44638***	05/1939312100	-49206445224	046100135505	C473059-9140	040017104984
181100000,000		250199753622	051996170909	_49346796447	^44923134515	C4R12457933#	049140792685
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051140000100		05,4981-1144	050987337374	-49516241329	047676014224	C48515032164	949266322357
241140000400			0509-2020170				
CATTANOGONAC		040-945124-1	050576333145	-49542>93403	046233910593	C44119018643	0404,14201517
UNITRECORDE	,		05/197/1409655				
051180600000			65796-433794				
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351340063mm			051263597709				
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ტუკინიერეგან ტაიფიანებები სომტეგრეგინე მსაკიწელშეთა და /Redisables და #77.706.198 nggr.pyracin nynigaunynyrg -633446955646 hafifh28489 046144794444 hafifa496635 us procedure 050790.01630 CO0902116390 -04442404830 007381751595 C08386578929 049243769298 PERARECSPRINT TRAINING THREE CHOCKETTAINS NAME OF CROSS AND PROCESS OF TRAINING OF TRAININ 0530 - 11131 - 0:0:0:0:310324 -09565162089 048202318116 044146760648 0:0032750384 05 14 + 1 647505 CUC 17U384225 - 473602747442 C484699+2451 C44207044574 047623567465 PRINCIPLE PROGRESS CONTRACTOR OF THE PROGRESS OF THE PROGRESS CONTRACTOR CONT 140 mm 5046 £ 6947 CUCY51851445 =#3626625949 CNG101937784 CNG1027263447 CNG951027893 وممرحت برويان 0511.7007240.000345575715 #09678650031 #69101142454 #6448646 #650105999764 +1 m - 51 2 1 1 751116-71501 CuC+3-231215 WC3629849798 C4948C93636-7 C44656405217 C3C1147CC461 Letonala and 001124202040 020932079206 409430076m34 04037874648 049733408250 050132003075 والمرامية MS1135J01C37 MOMIPUASO370 HIGASPTERTER PROGRATATION CHARGESTROM LSM14J940203 ومم علم ووعل Z. 6. 1944 - 1945 - 1946 - 194 وممرمتم بجريعي #51133907348 C3C413737377 -#OA4C763044 048972748754 C6G4984448780 @#C17391749G وحمر ممما وراعيا 051163104730 02027/497JA0 44964A122016 0497456444572 053140445640 0502440484 is to annother. ინკუ (გკოგისი იკიკიკნათოკნი სხონნრნიბონო როფსონიგონს შნეუსებოდა მომეს ეგომონი 45324010 A 10 n5;::::::237.5 0.0494*15385 44672:::977: 050107970493 0001#507201# 05022465446 -619 000,000 C51190072764 CUCHRICHOLES - MORMORES OF CHIEFFRENCE C50706100723 05023971A317 -4131000,000 051198073190 020800346363 ARG715672645 050189237969 050730987088 050257698403 , egazara, ang ^5[^\764[64? C:^F7]??QU#2 =#?7427[992# ^4C[73607:5] CFJ2476#?!40 @5/37/140U48 051716376439 03036361947) +69777913094 0502083644 050246428544 030227407380 Je 1330000000 n5,72448773# C3045/436023 -#9819915#13 0502F10475% 050317485747 050314690% Je ; Tymar Jor L -51955447754 (Uniquitys)-00 -00870925414 050244554404 050740405027 050542924117 Uriashanjano 051718974744 020084U188071 -89931727739 040301187774 050764977197 050367741918 SELANDED JOCO ANIDOM -004/2 PSANINEZIAS -FC100767100 PSC50164802/ PSC624410661 05739+134184 סחת מחחודום _5133000U000 **/5:266687930 | 120803698965 | F1318990885 | 050479729685 | 050507880/** 050487** C5127971267K C2C7932344A6 ##G13C#78486 C#C4#794C31# C5U#9#798584 C3C#47584U44 USIN JESSUFES 051582608C30 030782443305 HEISTHURPTION 050594805 050666402835 050524882375 J#1910000000 C512903#6U27 C30767132/92 -##161575596 0506/9310497 0506407#5468 050563755313 JE1420003000 C51747985110 C3075U020U00 4F010139571R 04C67626742 C5C7++3077757 03001U078979 Jegusean John 051705349638-05073U722391-=F02U5145-55-0402F332-1484-05U79-48276-050661944983 URIMATERATOR 05131254158* 05070839.90 #00233#63941 0408450847/5 050847148075 05087148075 J41430000000 JE14400000000 051319315HZ2 030693729,05 ==0264090147 046424612493 056497343949 036744034444 051726414347 000654751045 483712003052 051102047006 051101047401 050874550483 UN1470003000 C511373941/3 C30674723361 -40369168077 041112639046 561117470336 050971007974 JETAHOOF JOCO C513380C3980 C3C580 1495 -EC843828763 051174844574 C51197348687 051110718163 **451490003000** USIKUMMOSMOO 051344172244 CJC531C495CA -49647400461 C611567JO777 C51157571767 C5117/A976C7 C51344195184 C30469456165 --0706747767 051140744 C51144477399 05115453444 UR1810000000

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	051140000000		030084144401	-49711874196	-40126245759	048728007205	0493A92F:611	044959406741
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,	51340000000		050498408411	-50198058444	-49637871187	74-8659	C=C74=49574 <i>7</i>	05^112053144
,	351350000000	٠.	050A78374760	-50704451734	-49686122738	050312849109	0=0299799289	050112747748
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Ψ" 0=110n0000nn Stringcooper C4909900058 (57998012100 ="92065L2450 C48146AFG248 0474446AF228 048905466A590 351120053000 ARA-199724414 CSP006AS0214 LU3946S56449 BUF12C7472A7 PUS-6A77 AUS18S062S05 35113ncc2nna 230237101405 0509021150102912466 047412721929 048#18397293 049884015543 C5C39812080" C5C987512279 -44950878269 047991448970 048748260165 044290605644 251140000000 J51150000000 r50496590990 r5r982r07460 #49553749701 048196131936 049190163589 049499706381 USE JANGOUNDO 050594564737 05097690*989 .49584134705 048343008625 049144719008 044613358783 **451170000000** 05069188820 050970357420 w89608350862 0885913948; 669262929569 049731648793 u5:160003000 C50788575480 C50944242215 -49617564815 048832930224 0493922077CA 049854707289 050#846#9940 050906022655 #49820109**#29 04912001050**5 **0494140#490**A **0449827022#**G .si: voccuens 35120n000n00 34121A00UA00 CHITOTSCHIR CSCRASSORE -49635861280 0449274249744 049677366640 040125436341 ~512200C3000 C5111647551n C5C939-,13AHA _H8639561153 C49294H8685HQ Q497A9461140 Q5C139855198 951230000000 091126283754 090932400190 -49643788471 049378738477 049917249534 059154872844 051240000000 ^\$113557795* 050926133590 -#9649355653 049478459625 05010799386# 0501709256#1 451250000000 ^\$1144#^641^ ^5^919406340 -#9657014420 ##95#92077#5 C501####76BA _65^186#55565 J41260000000 C911539A918: 757912407490 -49867469815 C4977C731227 0501483A9803 050403908711 C\$1163065690 ^50006245480 _me681427441 040696641670 050146665268 050221739302 ^51:77093454 03039341339 _#9699597857 050106467307 05014674869 0502404666A7 USIZENOCOONO JSIZENDONANA 051181091070 050892237390 489771781236 050124679012 050218776871 050259980524 SOCCOSOCIEC CS1189937434 C5C8844671A0 449751668C47 C50149449264 G4074179377A C5C280537897 351310000nno C51198748994 C50877182280 -#6787277885 050175108299 050294920404 050203170344 \$51320000aaa #120747976# #5#86909An44 -4983056046C #502#77474#; 050703247112 65#3249744#4 21/13/2000/00/00 C51216128012 C5C860442340 -49882663844 C50275440748 C50344949799 C503449087668 251340000000 051224598709 050851409079 -#89944874878 050271027138 05039213262# 05037#632874 9513500000no C91233145654 C56841607686 ..40101871897 690310134645 090416840148 690401783181 \$513600000cc 091241518161 040830989990 =40110595903 0903933637 090899589738 090430730784 09174977147: 050819437A90 45012086972# 0504007447(6) 05044719455A 0504617157#5 3513700000000 U\$1380000000 051257903180 050606755991 -40122945627 050442841724 050444964720 pgr4450179+1 C\$126590307# 050792780200 -40147131483 050509879310 0505962477Q5 050530994300 451390000000 351#00000000 G51410000000 0917A1442440 050759924175 -50:83435A97 058640269Rfd 0507f03A58Un 050912R20673 -51988544000A 058745440777 440266629834 058714443184 056777882174 656856437392 351#3ncconna 051296243444 050718458495 -80234170975 050749228625 050842590204 050712380191 051440000000 C5170330409A C50603426040 -R0267101063 C50803139034 C5097A678083 C50771411494 G5145000000 051910100000 050000022210 49030086005 090978778995 0909971[0479 0508348349A5 951440000000 DADELFERNEN MANSAARRIIFO ESMASSAISEN MERGBECECOJ. MENGSECECE ACAGRIFIER G51476000000 ngin22771979: 050593959785 480416039926 ngii:9602080 09:110in3087 05:110in50487 951480000000 P3193500164 0504038880P7 -40599542200 0511453944040 051146701144 051127177444 051500000000 091738266624 050827430529 -90738398972 044140557844 041147574559 651177231440 9141000000 #5144219377# #503##760#7# -50997110702 #511763#54# #51177##5#5# #51177#3#5#

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J91440000000		050"5556507"	-50301#41413	-e0165198039	0505#88+7861	#3#1001AF0#0	050111182704
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CONCOONNIPO	•	090717540287	-50305, 3274	-40267801458	0907#3#23349	0=0=07843544	05^103939290
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G\$1500000000		050734574+ 07	-50448701405	~*0374#39>#5	050837045042	0504779904\$4	Bet Dinebéhan
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SREE SACROPHIC		05009060219#	-47575754435	-=1146986166	048415714849	049241347338	040964579295
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Patteuconuco ,		750767671474	-49932477741	-09762939=83	000149817966	049574875611	05/10/996090
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Setting country		150147173461	+5^116*824*0	-49764969450	0.14305539043	C497#1342434	050103425559
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951326600000						********	
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451510000000	,	90184A#3+44 =	5°496889746 .	#047#6#2406 (90859741 144	. A-11ALAM14 (4	4=4297[A6a]
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04009960070 050408012100 -49206542065 C4619C2C2738 047498864248 048926047480 **451110000000** 050190774200 050906080488 409346861822 047123471015 048184869324 048190188997 251120000000 151130000000 AS0796141414 (50992115740 -49442931449 047472335945 048474874904 A46292515541 050498120770 050987931840 -449508827889 048101462166 048793447150 048899483010 -51140003000 Ja::snnggang 050494509468 C50976303943 -49584208016 048340865398 049199712327 049427298497 **-51160000000** ~5049184782^ C5C970353185 =89608619875 088563930830 089288450550 049788276486 -51170000000 USE ERCOSSOCIO ^5078857447# ^5^964234145 =19617982^23 ^488418#0334 @1972953037# @44874131@43 351190000000 050984687748 050988009975 -49628725095 044122738095 049431444604 050100503384 351200000000 ASGG6017402" ASAGG1709208 449632624218 049170324065 049598212438 05014419541 05110750266* 050945362290 449637072703 049299346130 049651879460 0501282864+1 J51210000000 351220000000 C5111692450# C5C938968925 -49641192756 049301181038 04978747836# 05C183032483 J\$1230000000 05112424271: 050932435470 -49645941421 044387345457 040491123375 056156390784 35:24nnconn #51135575#57 (50926#45227 -49852145#47 #44449332479 (50116447632 #55174394247 351250000000 #511448#208# #55919486595 -49660577630 046608767366 060196717000 05019197780 as: senoconne 051153944840 050912823820 -44371959240 04478733557- 050384641641 050208536518 3512700000ng 0511670#9134 050906035210 -49687022475 04990670/525 050170440804 050226769618 ~5128000J000 051177CR4577 050899068426 -89706501873 050108805911 050184074275 05024585741C 3512900C0000 051181079017 050891888240 -449731189042 050129536874 050Z19653227 050265871283 J51300000000 051189971414 050884024473 -49761921752 050142844944 040747282024 050286889246 Sizinoconoc 05119872742# 050876A27075 -449799642211 0501790#533# 0402770A779# 05030900449# 351320000000 05120745256# 050868405068 -#9845383422 050208374726 050303123064 050532321286 35133000000 c41216094044 C5C859A89475 449900342937 040246940294 040343576447 04635314 ~31340000nda 05172464444 05085C7624AL -49965864455 050277174101 050340544625 050361070661 סהרסססחפרודע 051233099154 050840332470 480104354332 086317193045 080826285823 056410814799 351360000000 ^5124144A;7# (5^829444432 -80113521498 /463A1348723 CROMA2788708 /4644/4907#6 351370000000 051249645034 050817475725 -40124309714 050409853144 0405045636366 050472042644 051257795787 C508C44206P1 -40136980697 050463146888 050987276818 05098684664 951380000000 351390000000 J91400000000 051273592959 050774062603 -50109331651 050505173588 050645979342 050582685090 \$51# Londonne 051281240660 050756142100 -40189901116 0506447544CQ Q9Q798346760 0500263Q65A9 291420000000 ASI28A7A7010 CS0735058233 -S0214192A54 CS0730597760 CS0701349C00 054674374704 C51295947AAP C50713157445 -40243028886 050813194720 050881412394 050727958549 051430000000 051702960757 050687164876 =40277497888 050903069761 050937144194 0567886038988 J51440000000 051450000000 351460000000 051716497757 050623034378 #80369983458 051116717786 34116886498 0569369838+5 351470000000 091727172024 050963047070 -=0437321723 051172240963 0511#0711440 0514U5156949 JS1480000000 C51727770ART C50575786041 -40514145448 051174849550 041141544730 p4114800295 45149n0000nn 051932817A69 050479980971 480621098014 081148448874; 091149771077 031429-40584 951900000000 05173727559# 050#101637## #80770393912 051163748977 051197719#81 051154132295 051910000000 64.946971049 656323986678 -40099036173 651160208391 Ustimadeceus 651181639091

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U\$1150000000		C50496540#40	C5C942C05410	-49553886967	048202796934	019121107946	040516741670
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	051110000700		050998631980	-49227956490	-e0206414416	047444170205	01091741027	C44945756301
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65111000.0cc 351120003000 5511 Williams CSUSTRIBLE -- GRADEWILL -- GRADEWILL COMPANIES -- CONTRIBUTE -- CONTRIBU . Fillungebore C5C08414243# +497120247#4 #51245#3#3#12 0447#59#1494 6493##6#616# 654101572144 251150000000 05007642077F =49859844400 =60109845778 049173635908 049807017600 050105158482 + 3117010 and C5CC57aC571# =5C1A2RX74AO =446P5A764190 OL92H5518RRJ C4471410aC3R O5F1079374H3 USI LANCOUCH 050047;#4044 450110070407 4897688;2038 049372534140 049894788404 050109169244 ممع مدميوية מידנטנ מררן **פ**ינ CHOCKERGIANIA -50174870/NR -49440456888 0405094728AS 04018457198 6501119834Ad deles continen 0500100#7470 -50130880965 -89595197054 049619611023 05011#72558# 050112384241 050097499874 -50176018245 -00560301711 049700904345 050197011980 050113722875 3512200030nno 0408, 567440 450191879898 449534549895 049673531870 CFC:45401608 C56114201493 051230000000 451240000000 C5C809172477 -5714713A780 -895171(879) AEC1017/9707 C8C18989674 ACALLONSONAL CREPARTURDANA C50854147846 -50142234131 -69407169881 050117331676 050141464856 050113906544 251240003500 05C#5868407# #50107700175 ##9500373#30 05C1740022#3 USC174U10557 050116537795 :5127000J0n0 ^5C^227^789^ =5^(A294A)N4 =#05C#23646 04C#1939524 C#C##1710149 65P1172176+U 351290003000 OSCRORATSSOR ASCHARAGERY LUGSINGIETZ DECITICAGER, CROTEGRARAGE ARBITHANACHE 251250003000 C5C789471127 +5^1172737477 -60535736404 05C101235744 05C2C82782C8 05F116429763 55) 10000130e6 C4C771U41177 -50176218776 -89558480148 050212603984 C4C270136664 050114484519 3*1 11 CUCSONE 0507530HW790 -50183628463 -H9988008677, 050275297505 -050757946507 -050114W30441 0513200000000 ngorinkanata utalagamilar wakazaiganka ngozago/gitu dtG7kiuJ7G74% ashilyA36Gi3 G51330003010 050714394674 -5010683>298 -89667286874 0502440/A963 040244045842 050120186665 ofitacocine 050A9A0/2797 -50303971007 -49717670P35 09031020738- 0902A8085600 054120887346 05135000000cc C5CA748ACC20 -50031647 -89775888827 05C374547126 CRC28C111457 05C12063167G CACASTSTAAAN LARGINATIONING LICAMADURCADE OSOSIASIASIAS COCCUST SETTA CONTRACTA CRESACCODOC 051370003000 05043104317# -509277113#0 -#4901#291#45 050306137524 C#C709241957 050123A966#3 GSIBANGCONCC C5C46354907# +5C3#7R3AAH6 =#0110191706 04C4893+A335 C#UR9#1#592# 05C12033R292 CALBRACCIONA 050=54znusun +503±4397x35 +=0141251054 050402830106 0503403=508A 050114756797 d514cccccccc J#14100030rd 050=31001AC= -5007213A-07 --0135821140 05052740AY15 0503473A1358 050119066A4 aB142000unno 010503773134 457240220404 450148156639 090563287490 050744440055 050114124372 C408743440004 -50401834440 -401046C2418 04C6CC246424 C4C344917837 050116482347 05143000-000 G51446003066 000443305464 -50 ***>227156 -5018/618/69 0506486-4474 050387544290 050115271941 051450003000 090010494964 -5799866775 -F0205809710 040577777950 05034846058 050113214255 CSIMANCCORNO C5C774401127 -57746454440 -40232214740 04C718230501 34C417148424 057110593044 G514700F3000 0=173827347# -50145787A94 -497648[+789 040149841425 04048[UA0527 055107765065 0514400000000 0507983[455] -50413-414[-40303744]37 040802430[AG C#C44]570594 65610300031/ ********** #302233268857 -50466594373 -40354978019 040476186570 045441454137 044975230018 051500Ccanno C9C2OR#72864 -9C48524548 -FG425184903 C4C480734447 CEC441G16938 G44902444286 09015907889# -50442458### -###31703#34 ###Q444-4995 ##@##\$U#.777 | :-*U%44307+7 C414 10000000

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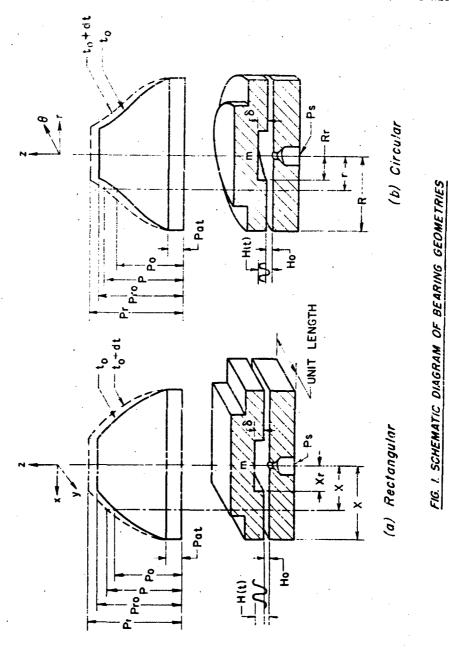
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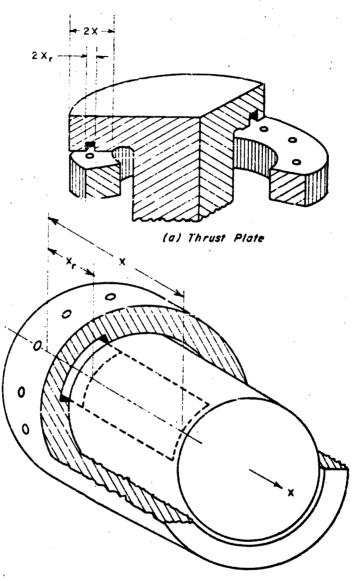
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(b) 'Equivalent' Slot in Journal

P.W. Z APPHUXIMATIONS TO RECTANGULAR GEOMETRY

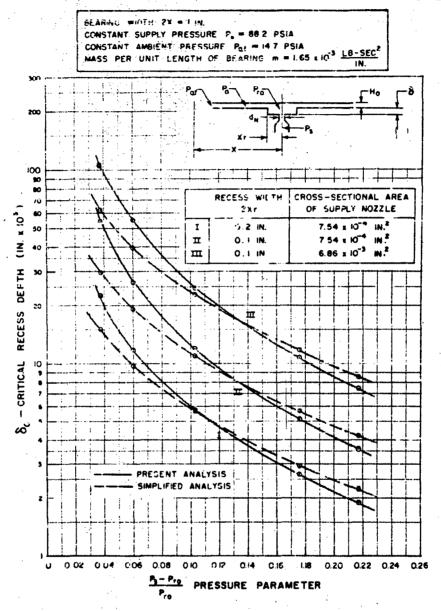
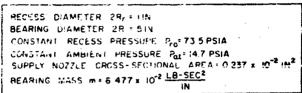


FIG 3 CRITICAL RECESS DEPTH vs. PRESSURE PARAMETER (CALCULATED)

(Rectangular Geometry)



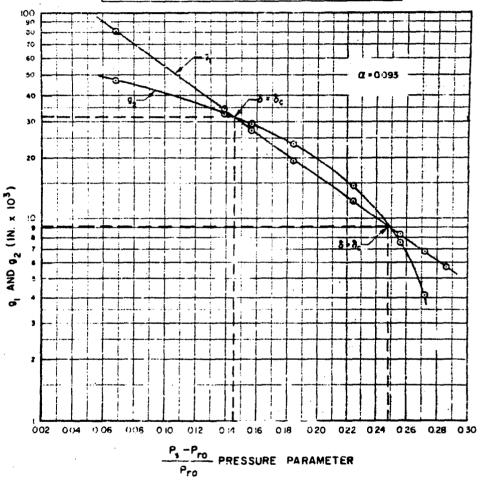


FIG 4 DETERMINATION OF CRITICAL RECESS DEPTH (EQUATION 43b)

(Circular Geometry)

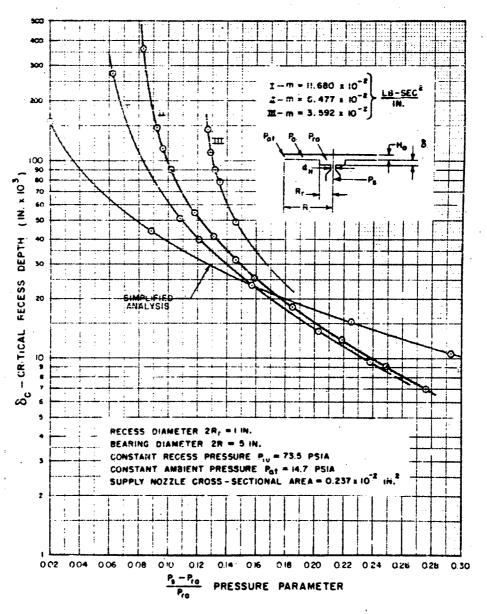
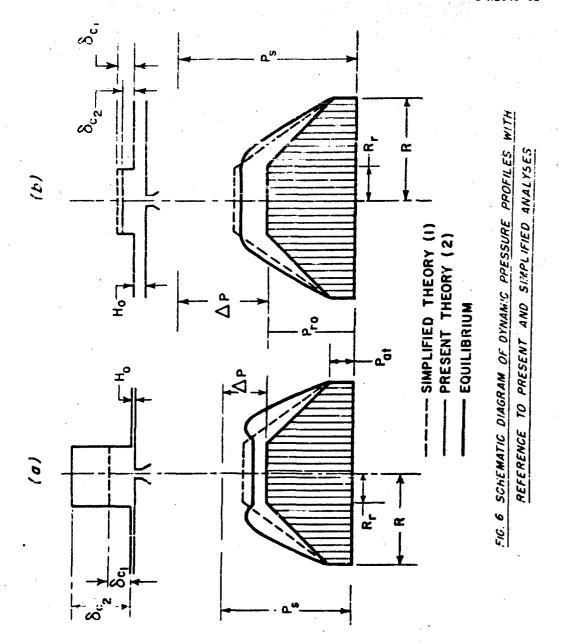


FIG 5 CRITICAL NEGESU DEPTH -3 PRESSURE PARAMETER (CALCULATED)

(Circular Geometry)



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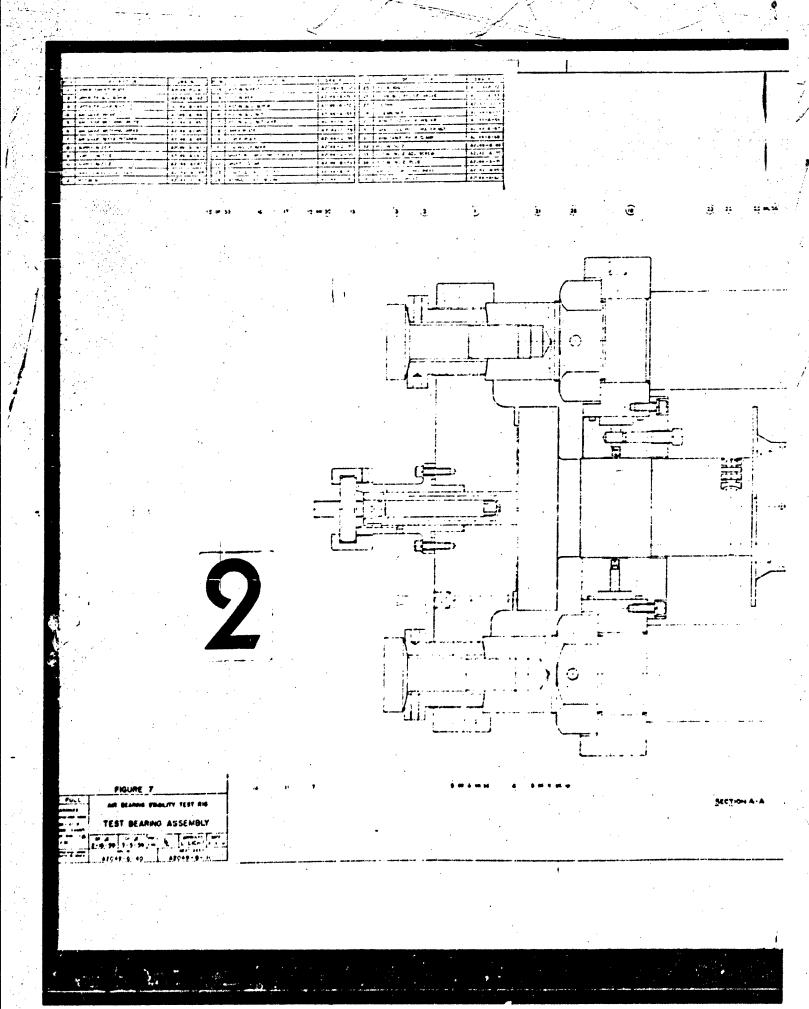
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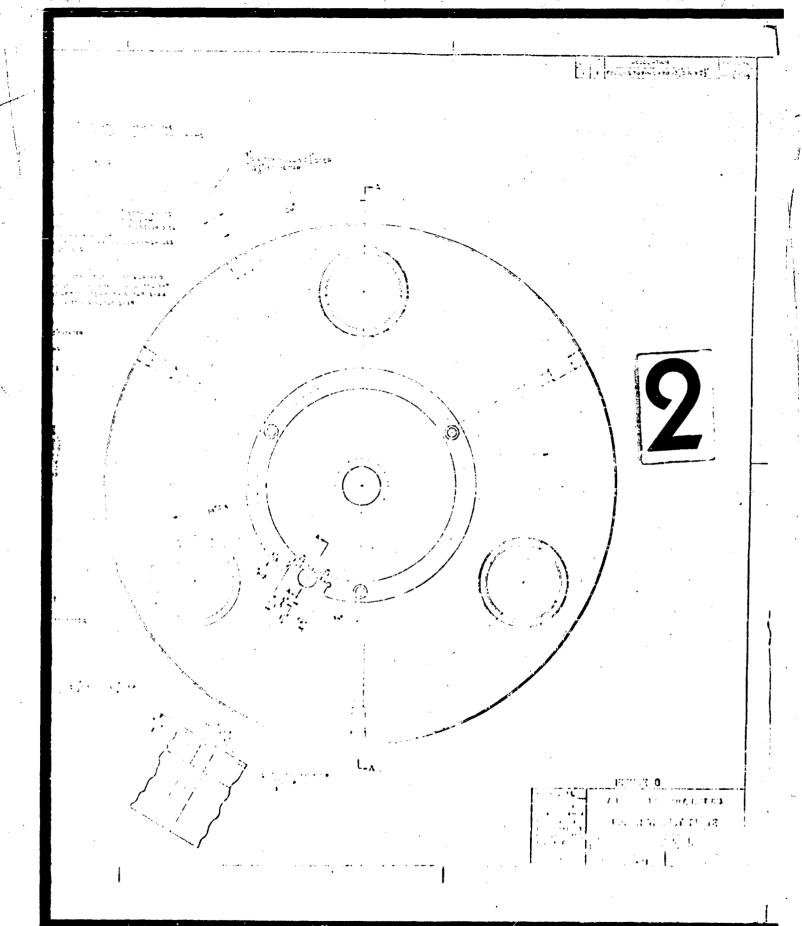


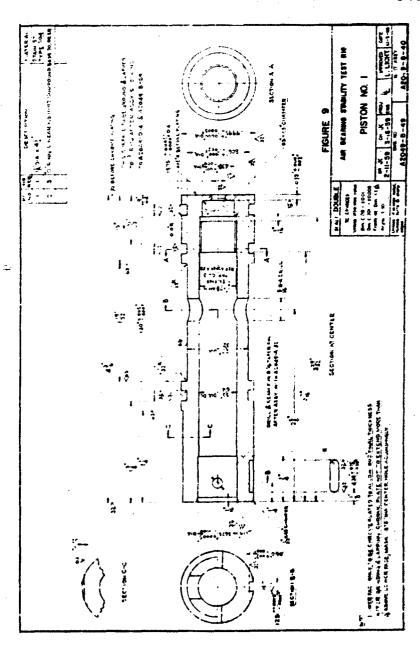
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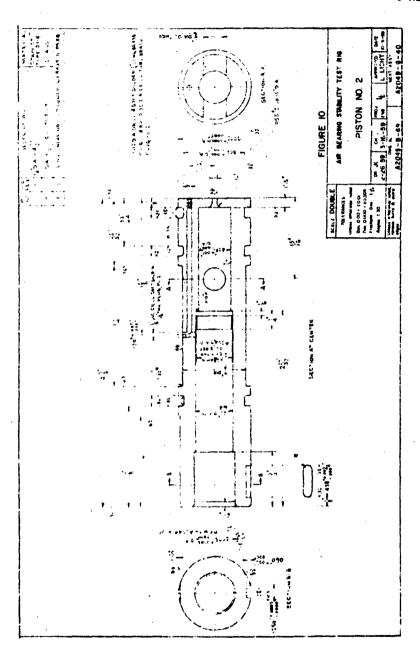
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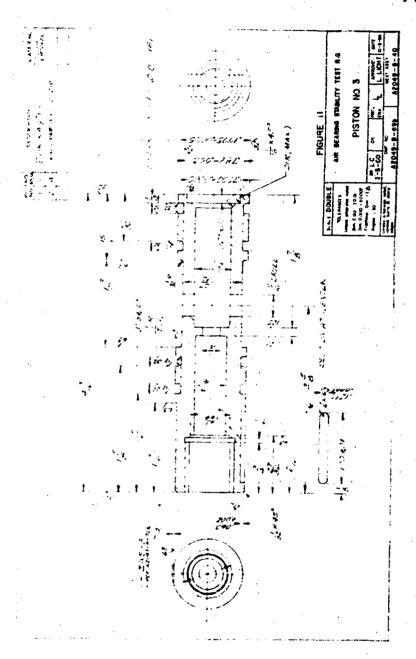
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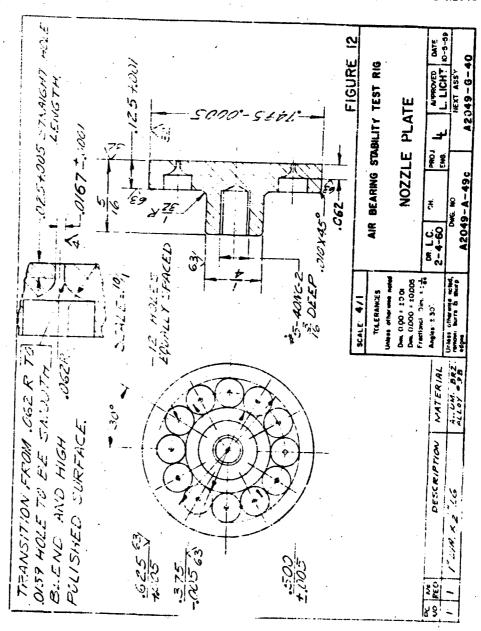


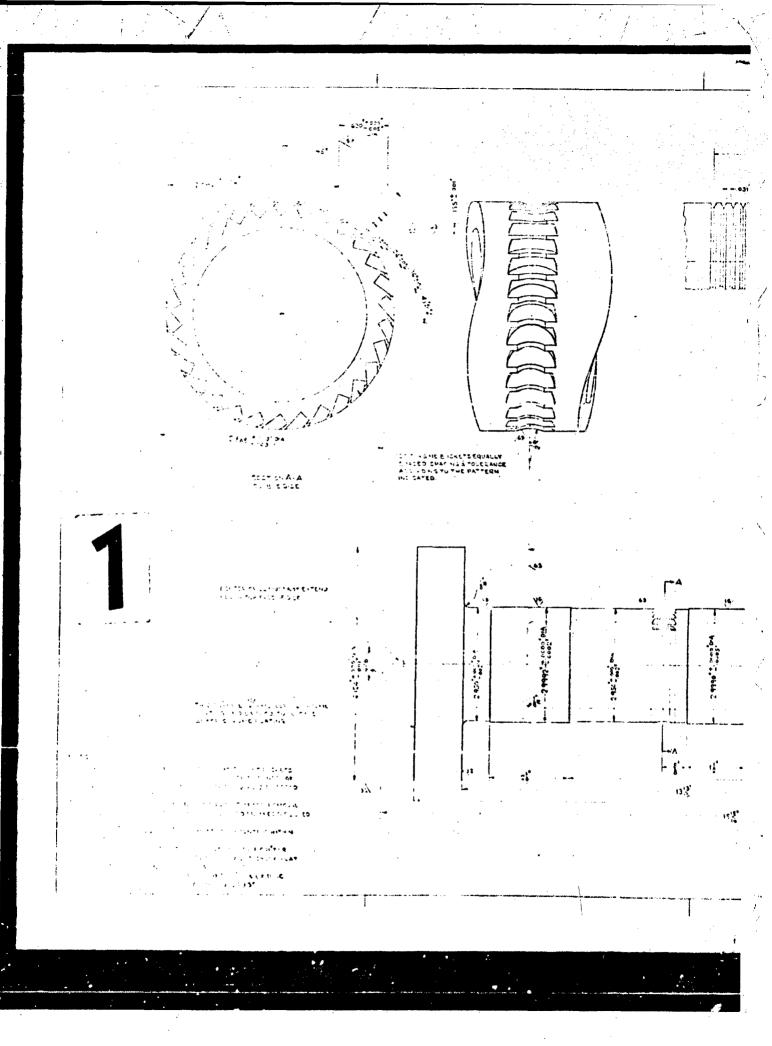


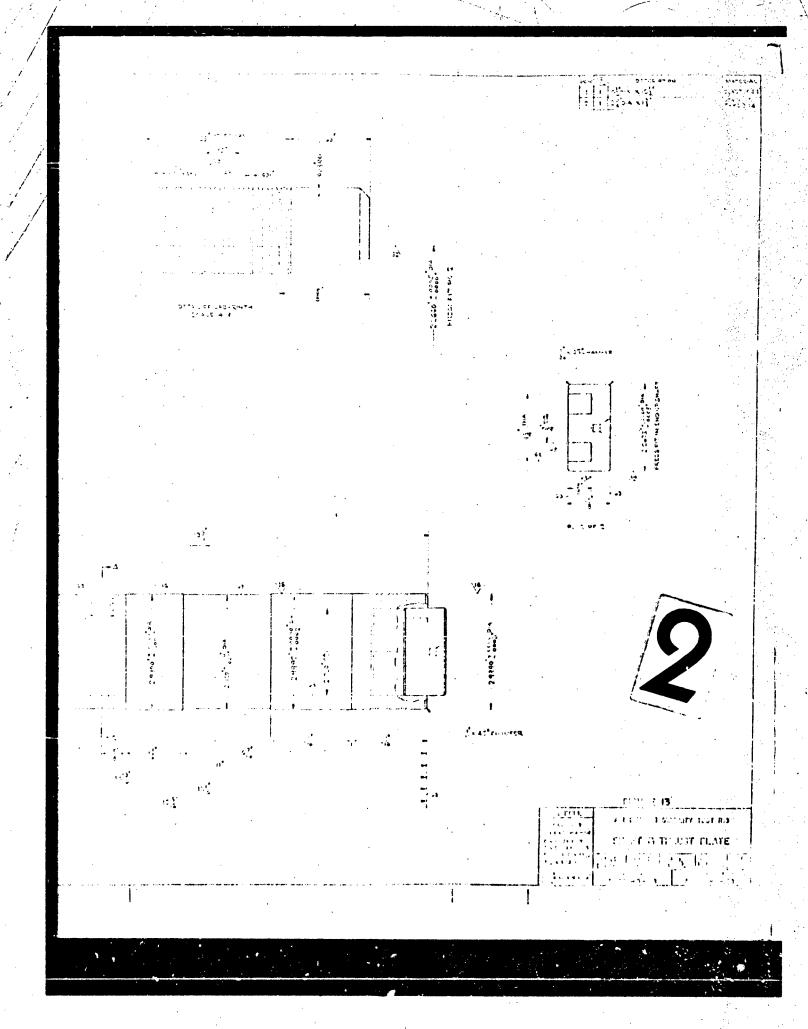


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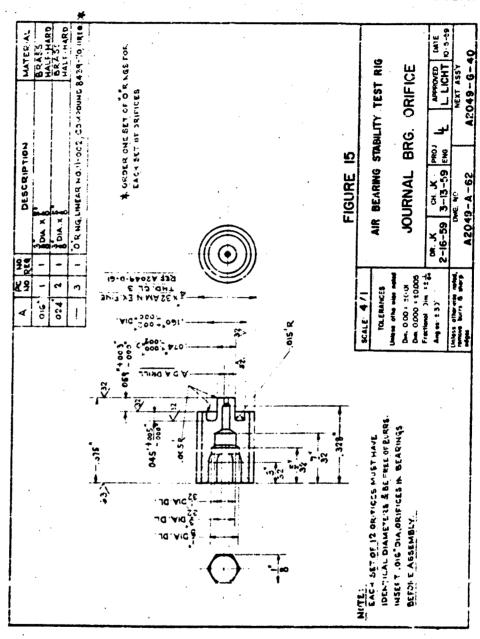






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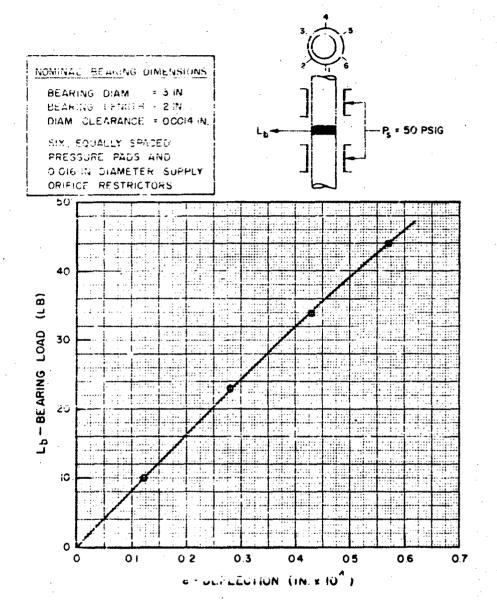
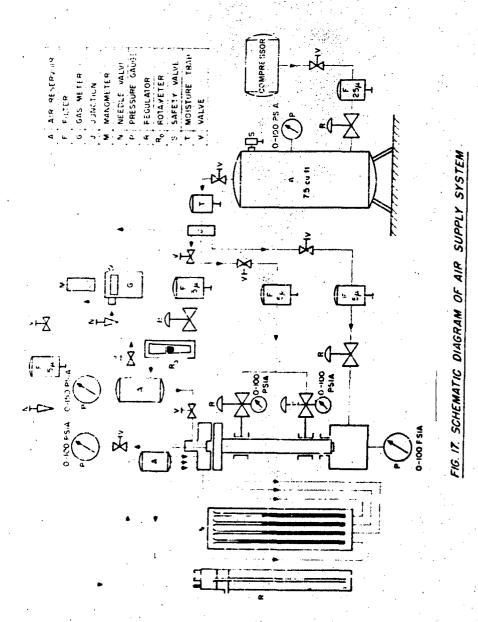


FIG 16 LOAD - DEFLECTION CHARACTERISTIC OF GUIDE BEARINGS



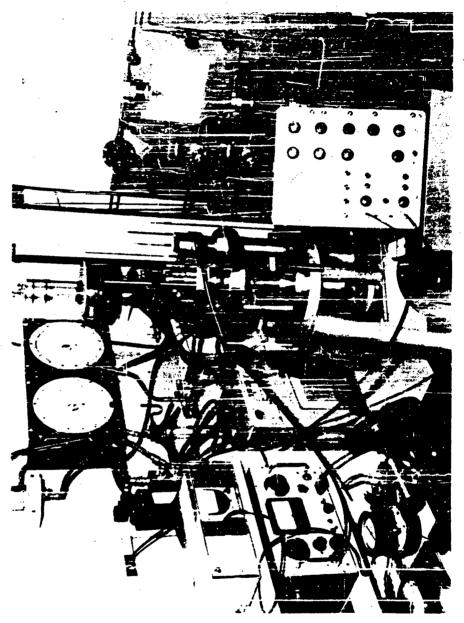


FIG 18 VIEW OF TEST APPARATUS, INSTRUMENTS AND AIR SUPPLY SYSTEM

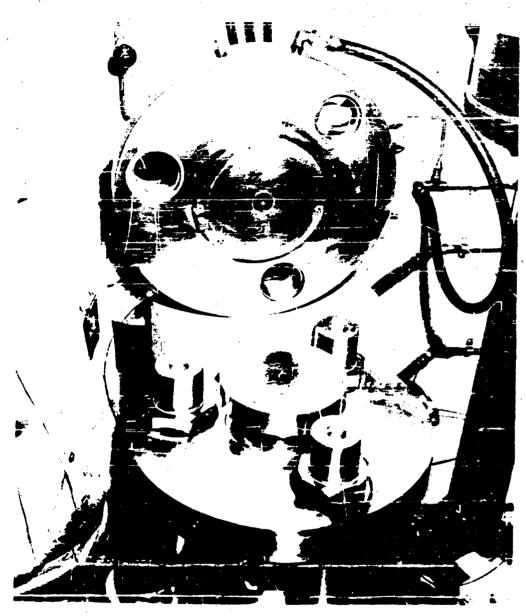
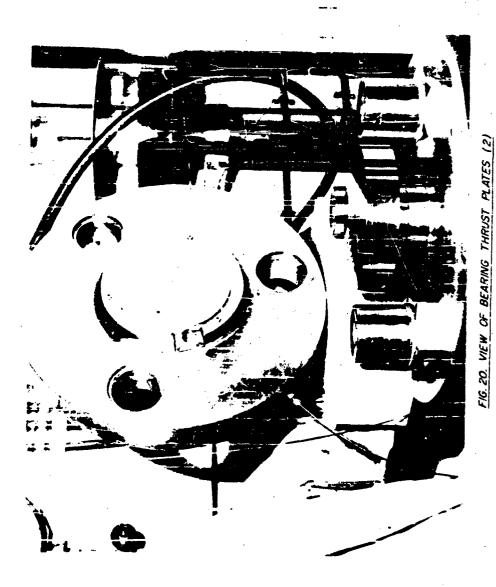


FIG. 19. VIEW OF BEARING THRUST PLATES (1)

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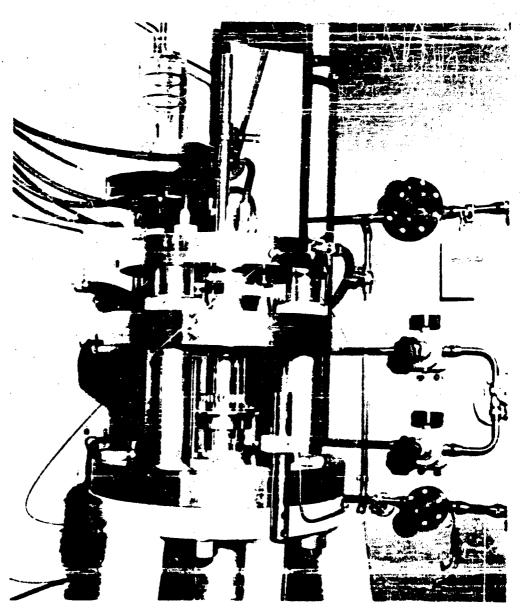


FIG 21. CLOSE VIEW OF TEST BEARING ASSEMBLY.



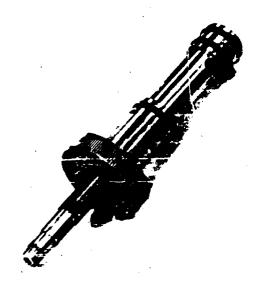


FIG 22 MODIFIED PISTON NO 2 - SECONDARY RECESS

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FIG. 23. NOZZLE PLATES FOR PISTON NO.3





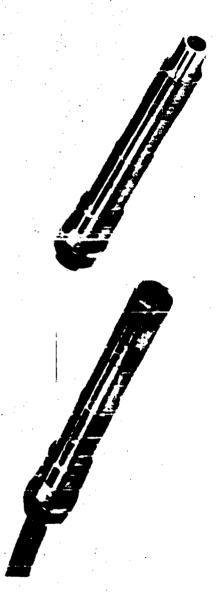


FIG. 24. PRIMARY CAPACITANCE PROBES AND PROBE HOLDERS

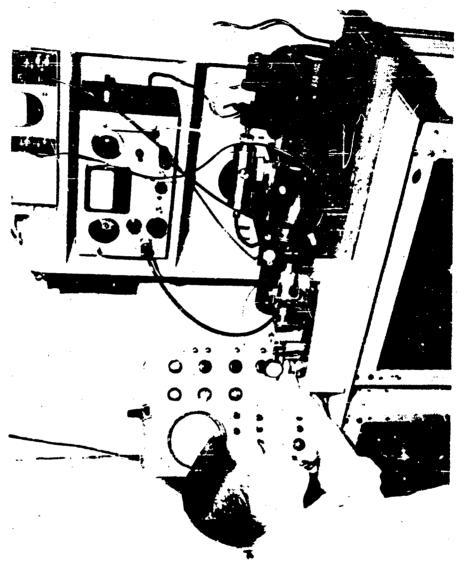


FIG. 25. CALIERATION FIXTURES AND AUXILI

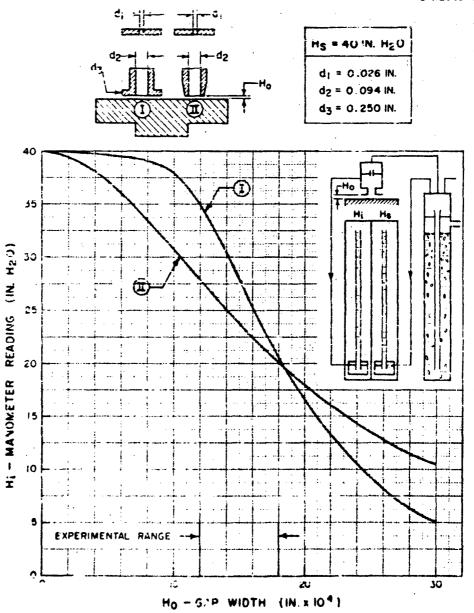
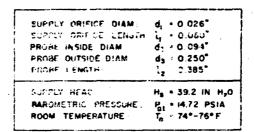


FIG 26 CALGULATED (APPROXIMATE) AIR CAUGE CHARACTERISTICS



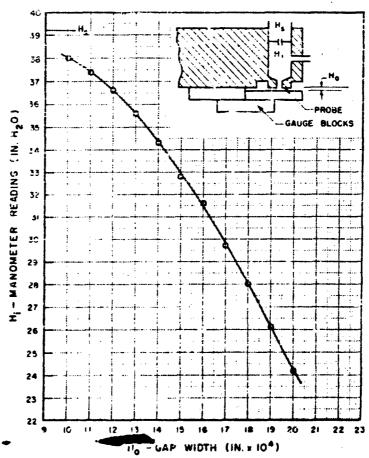
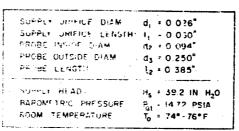


FIG. 21 CALIBRATION CURVE.



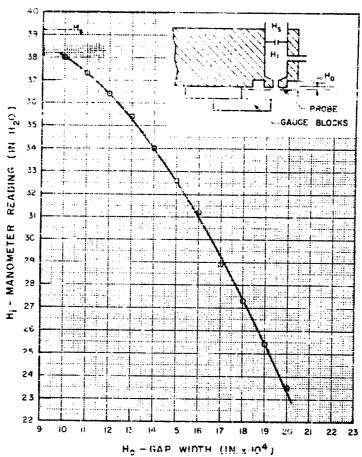
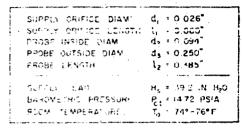
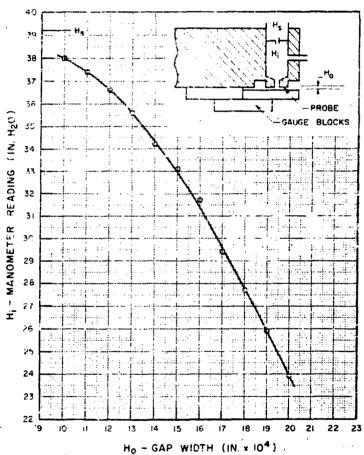


FIG. 26. CALIBRATION CURVE

(Air Gauge No 2.)





[10.29. CALIBRATION CURVE (Air Gauge No.3)

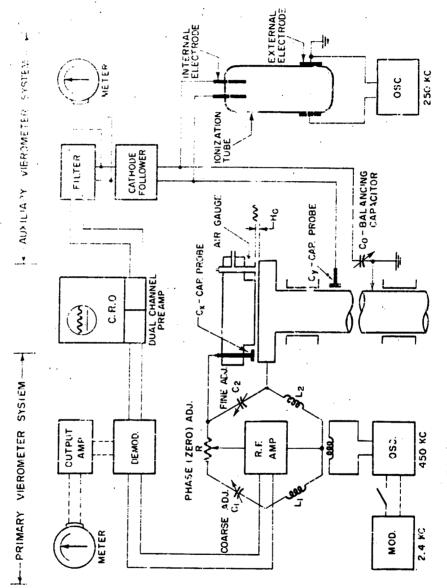


FIG. 30. SCHEMATIC DIAGRAM OF INSTRUMENTS FOR VIBRATION DIETECTION AND MEASUREMENT

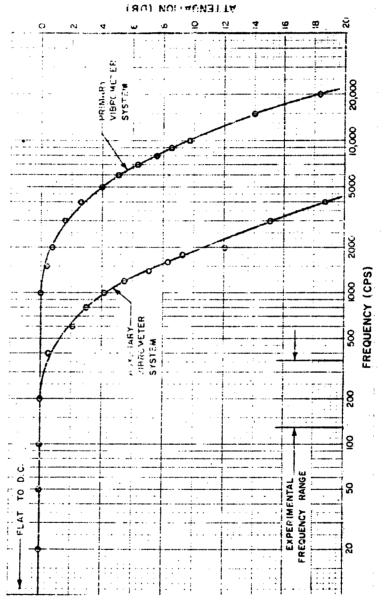


FIG. 31. FREQUEITOY RESPONSE OF VIBRATION INSTRUMENTS

PROBE DIMENSION:

, 0.25 IN. DIAM

INITIAL (NULL) OFFSET: 4.35 x 10-3 IN.

SENSITIVITY: 1.05 V/ 10-5 IN. AT NULL POINT

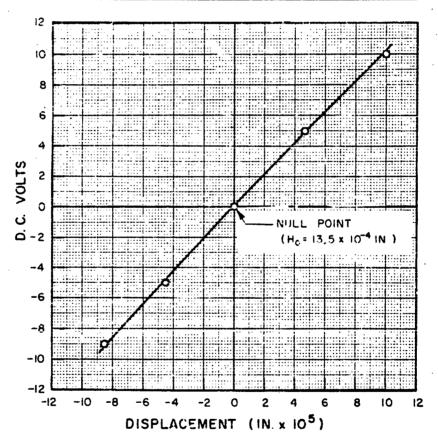


FIG. 32. CALIBRATION CURVE I. (Primary Enpacitance Probe)

PROBE DIMENSION - 0.25 IN. DIAM INITIAL (NULL) OFFSE): 4.50 x 10⁻³ IN. SENSITIVITY 0.95 \(\times\) 10⁻⁵ IN. AT NULL POINT

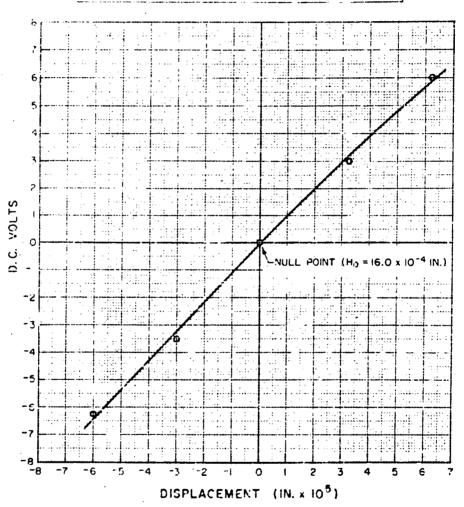


FIG. 33. CALIERATION CURVE 2
(Primary Capacitance Probe)

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PROBE DIMENSION: 0.25 IN DIAM INITIAL (NULL) OFFSET: 4.80 x 10⁻³ IN. SENSITIVITY: 0.95 V/10⁻⁵ IN AT NULL POINT

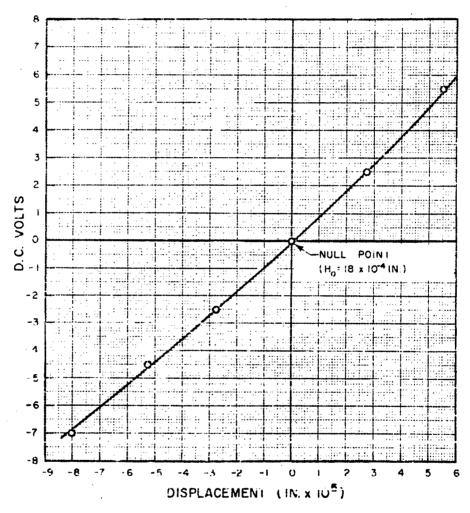
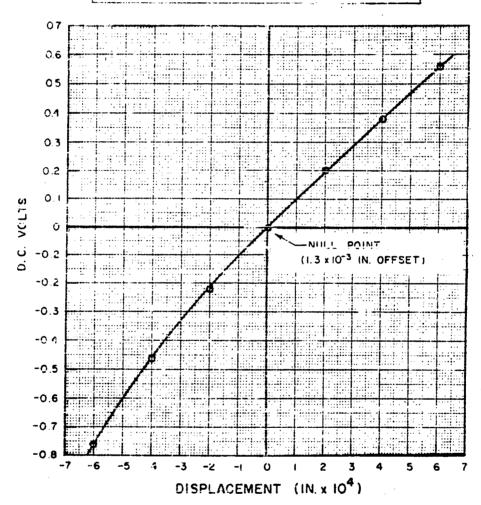


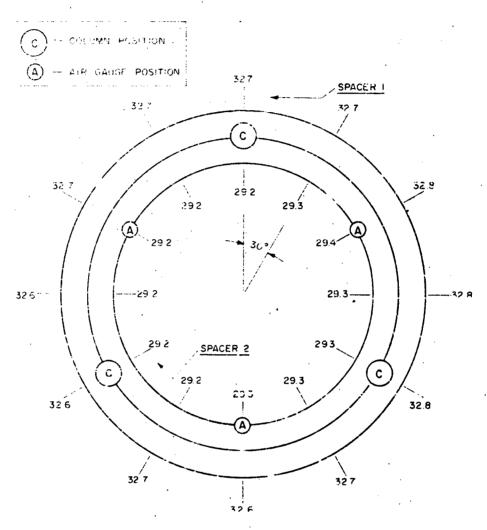
FIG. 34. CALIBRATION GURVE 3.

(Frimary Gapacitance Probe)



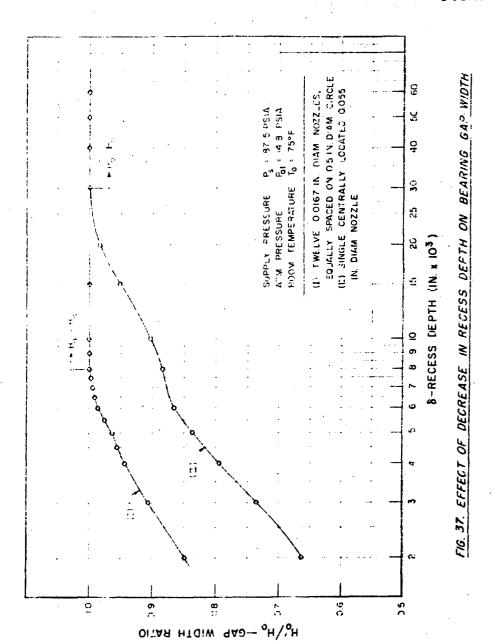
ris. 35. CALIBRATION CURVE . (Auxiliary Capacitance Probe)

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NUMBERS REFER TO MANUMETER READINGS IN INCHES H20 (SEE FIG 27)

FIG. 36 RESULTS OF THRUST PLATE ALIGNMENT TEST



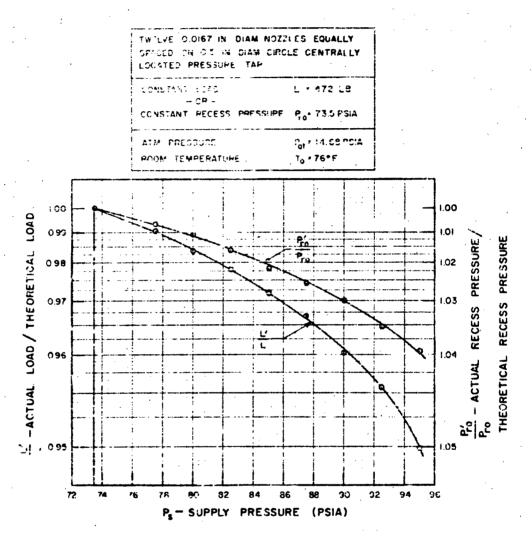
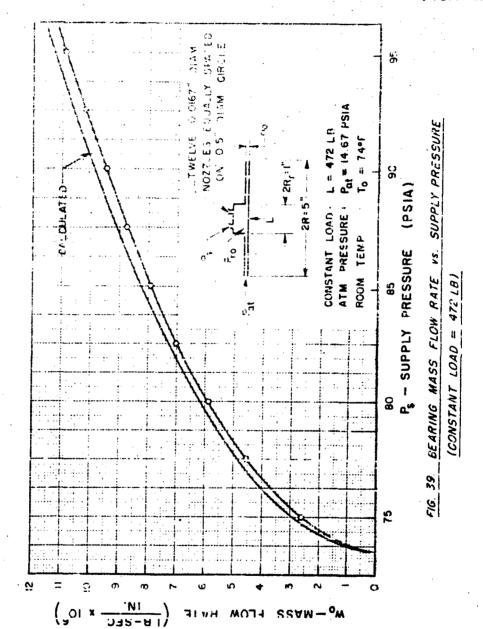
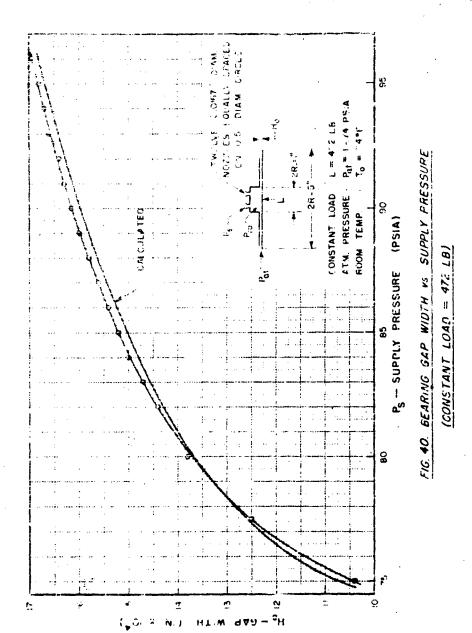
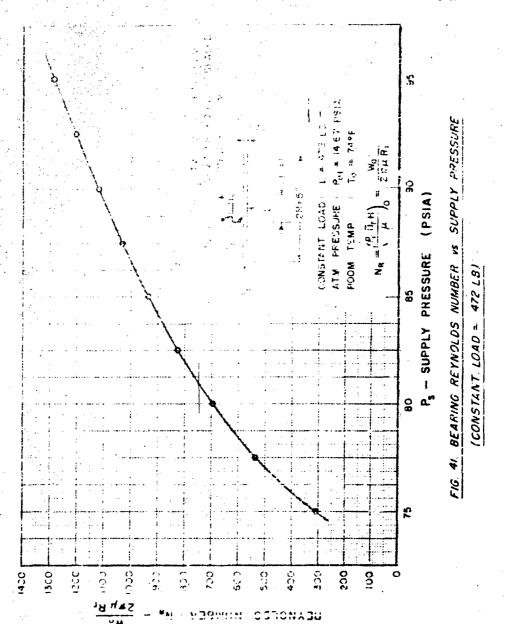
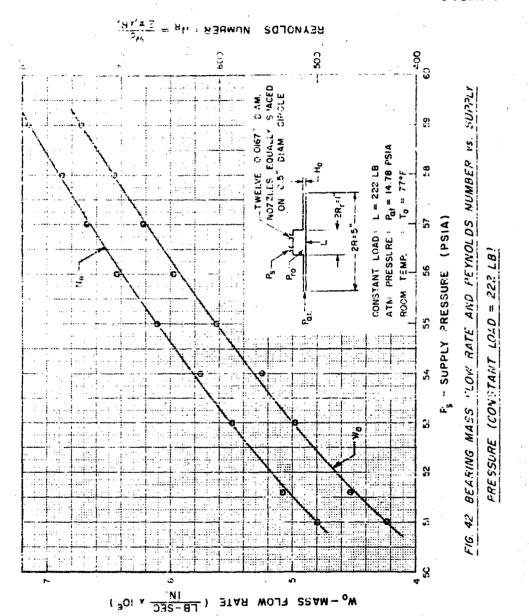


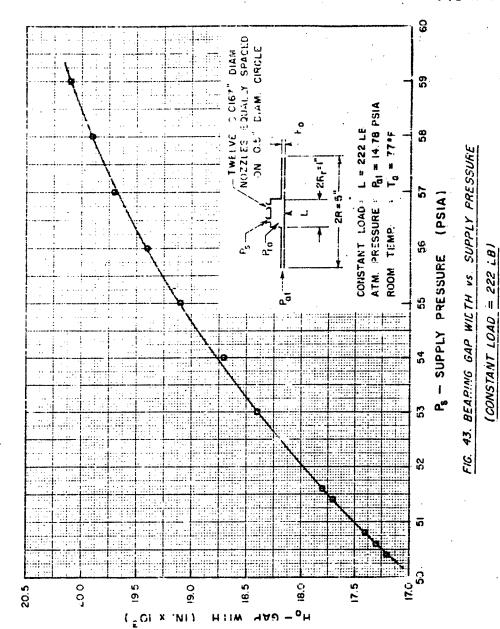
FIG. 38. VARIATION OF LOAD CAPACITY AND/OR RECESS PRESSURE
WITH SUFFLY FRESSURE











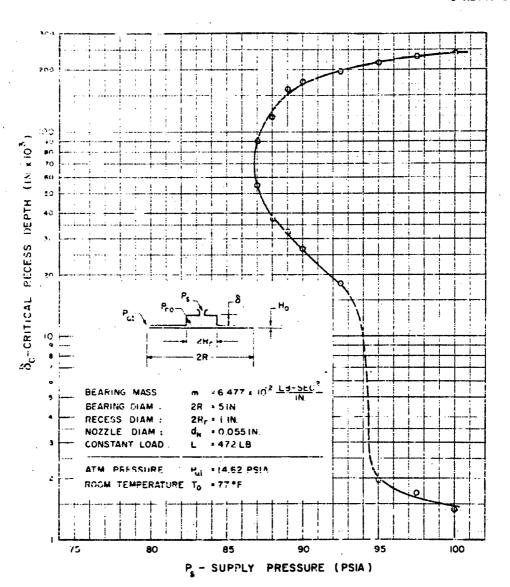


FIG 44 CRITICAL RECESS DEPTH vs. SUPPLY PRESSURE

(Effect of Decreuse in Recess Depth for

Single Nozzle Supply)

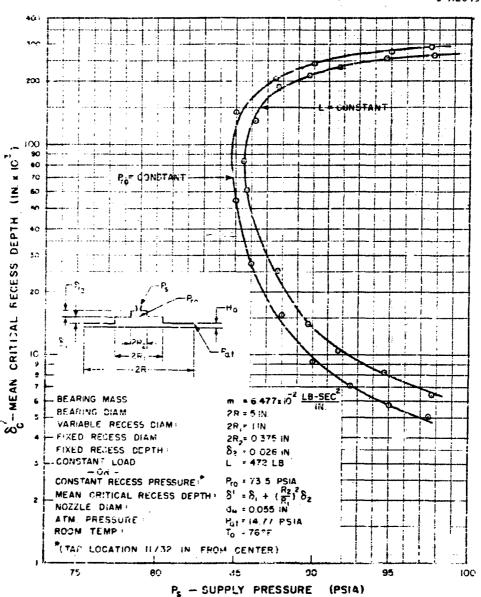


FIG. 45. MEAN CRITICAL RECESS DEPTH VS. SUPPLY PRESSURE

(Results of Constant Load and Constant Recess Pressure Tests)

Modified Piston No. 2 and Single Nazzle Supply

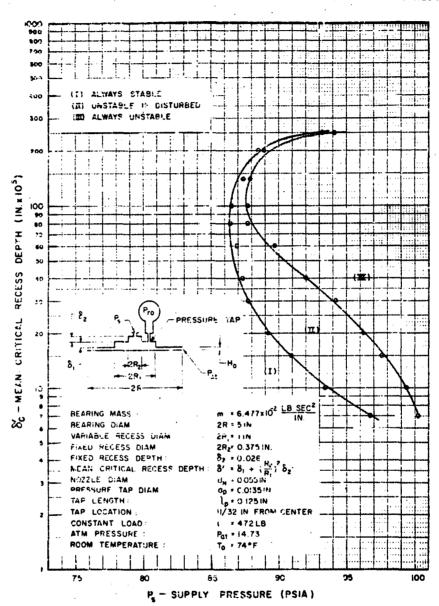
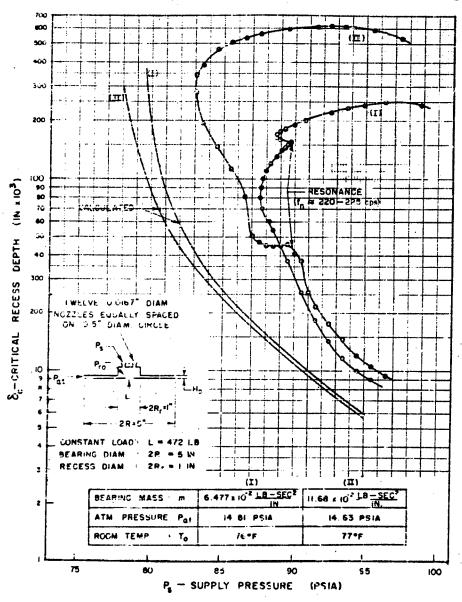


FIG 46 MFAN CRITICAL RECESS DEPTH vs. SUPPLY PRESSURE (Hysteresis Effect)

Modified Piston No.2, Single Nozzle Supply and Open Pressure Tap



(Effect of Resonance with Non-isolated Test Stand)
Twelve Nozzle Supply and Piston No 3

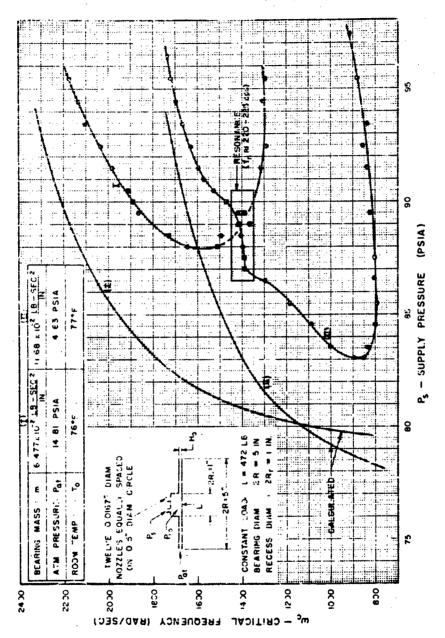
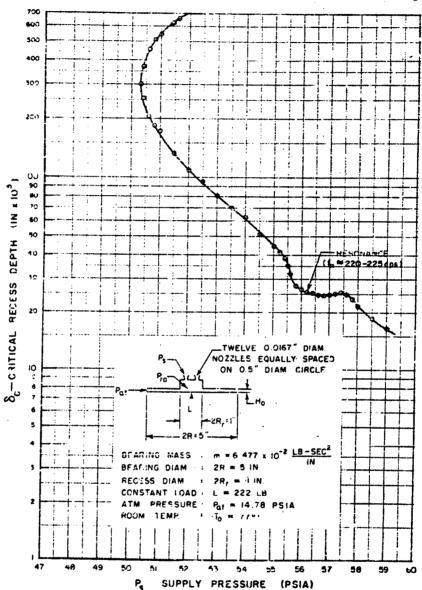
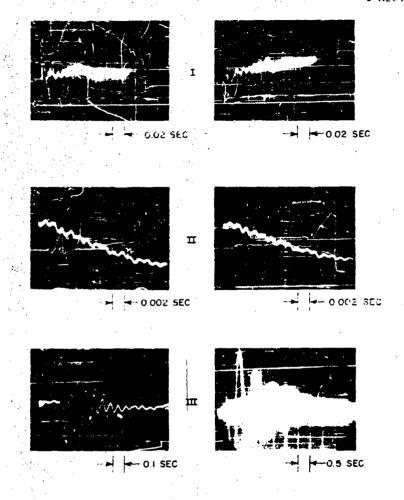


FIG. 48 CRITICAL FREQUENCY vs. SUPPLY PRESSURE (Effect of Resonance with Non-Isolated Test Stand)
Tweive Notzli Supply and Piston No. 3



(Effect of Resonance With Non-Isolated Test Stand)
Reduced, 222 lb Load, Twelve Nozzle Supply
and Piston No. 5



- I THAT PIG AND GASE MOUNTED DIRECTLY ON FLOOR (220-225 CPS)
- H. UPPER THRUST PLATE SECURED TO COLUMNS (730 CPS)
- III FEST RIG AND BASE MOUNTED ON ISOLATORS (15 CPS)

FIG. 50. DETERMINATION OF NATURAL FREQUENCIES OF TEST STAND
AND UPPER THRUST PLATE

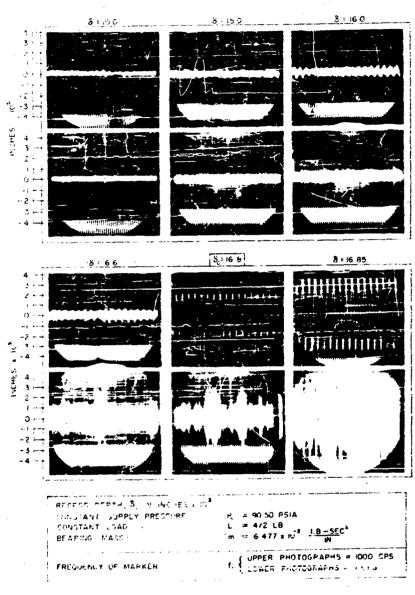
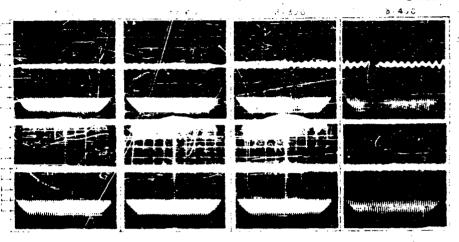


FIG. 51 AMPLITUDE GROWTH OF AUTO-OSCILLATIONS IN AFPROACHING
STABILITY BOUNDARY (Ps = 90 50 PSIA)

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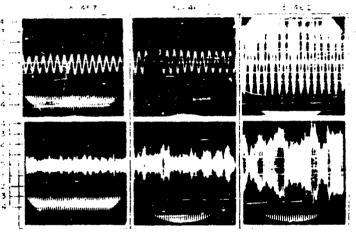
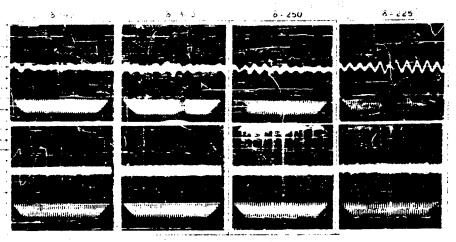


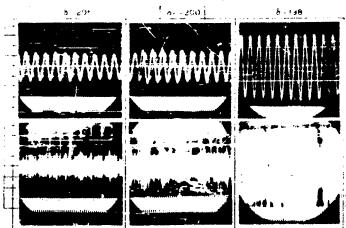
FIG. 52. AMPLITUDE GROWTH OF AUTO-OSCILLATIONS IN APPROACHING STABILITY BOUNDARY ($P_S = 87.50 \text{ PSIA}$)

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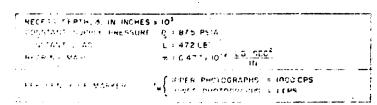


FIG. 53. AMPLITUDE CROWTH OF AUTO OSCILLATIONS IN APPROACHING
STABILITY BOUNDARY (Pg = 87 50 PSIA)

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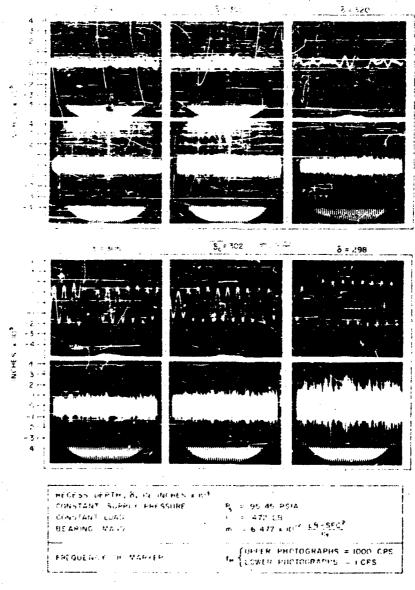


FIG 54 AMPLITUDE GROWTH OF AUTO-OSCILLATIONS IN APPROACHING
STABILITY BOUNDARY (Ps = 95.45 PSIA)



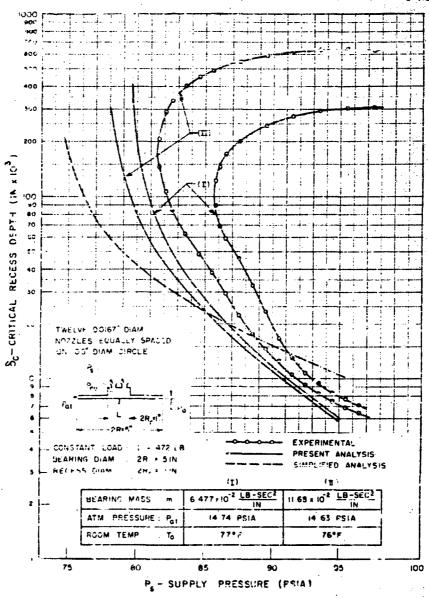


FIG. 55 CRITICAL RECESS DEPTH vs. SUPPLY PRESSURE

(Concluding Results)

Twelve Nozzle Supply and Piston No. 3

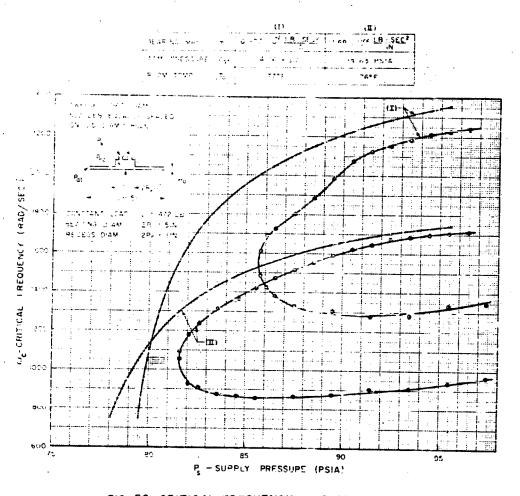


FIG. 56. CRITICAL FREQUENCY vs SUPPLY PRESSURE
(Concluding Results)
Twaive Nozzle Supply and Piston No. 3

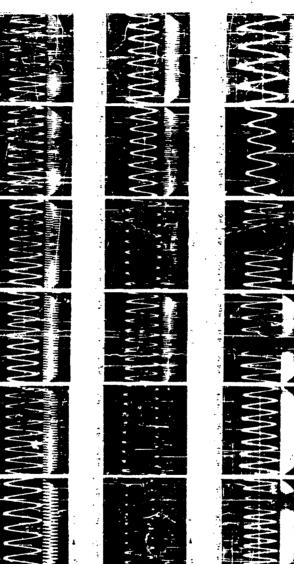


Ber GRITICAL RECESS DEPTH (IN x 103) - CRITICAL FREQUENCY (RAD/SEC) L - FREQUENCY OF MARKER (GPS) P. -- SUPPLY PRESSURE (PSIA)

FIG. 57. DETERMINATION OF CRITICAL FREQUENCI.S I BEA. PING

MASS = 6.477 x 10-2 LB-SEC 2

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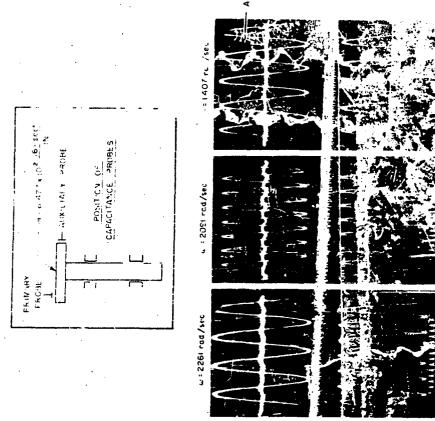
CHITICAL RECESS DEPTH (IN A LO FREGUENCY (RADINSEC FIG. 58 DETERMINATION OF CRITICAL FREQUENCIES (BEARING

MASS = 11.68 x 102 18-SEC2

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64 x 10° 1N = 5 (AUXILIALY) (PE IARY)